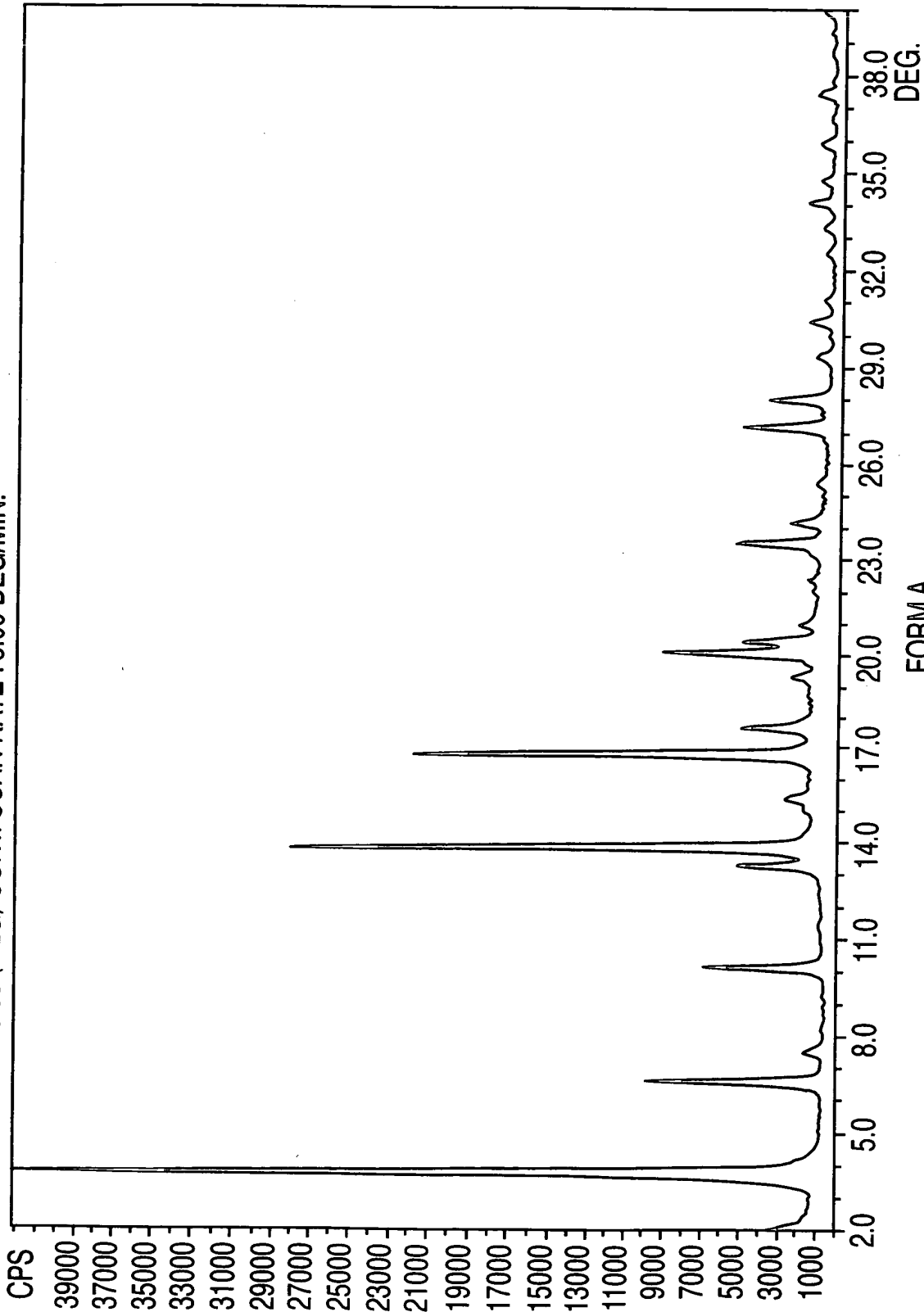




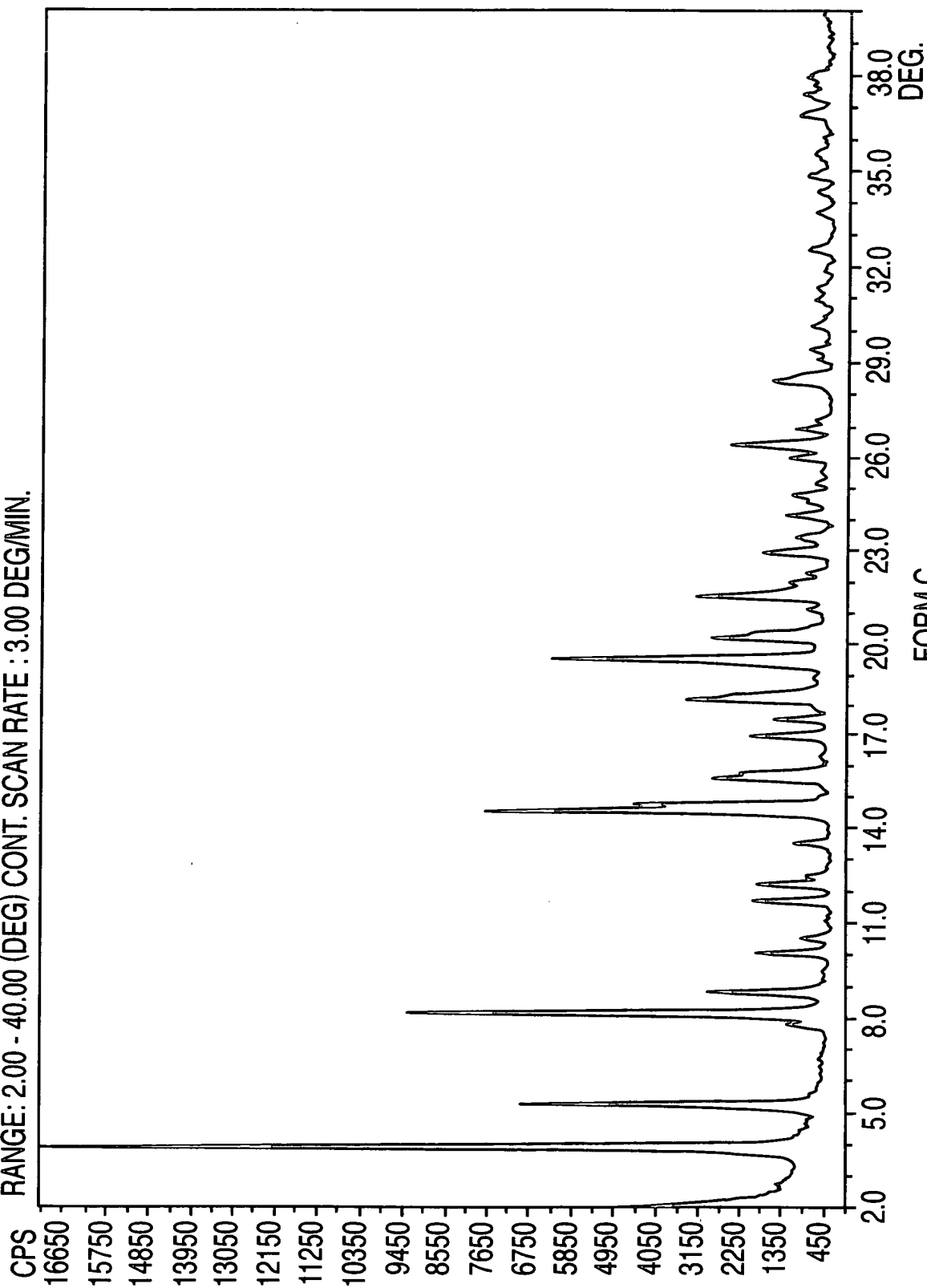
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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



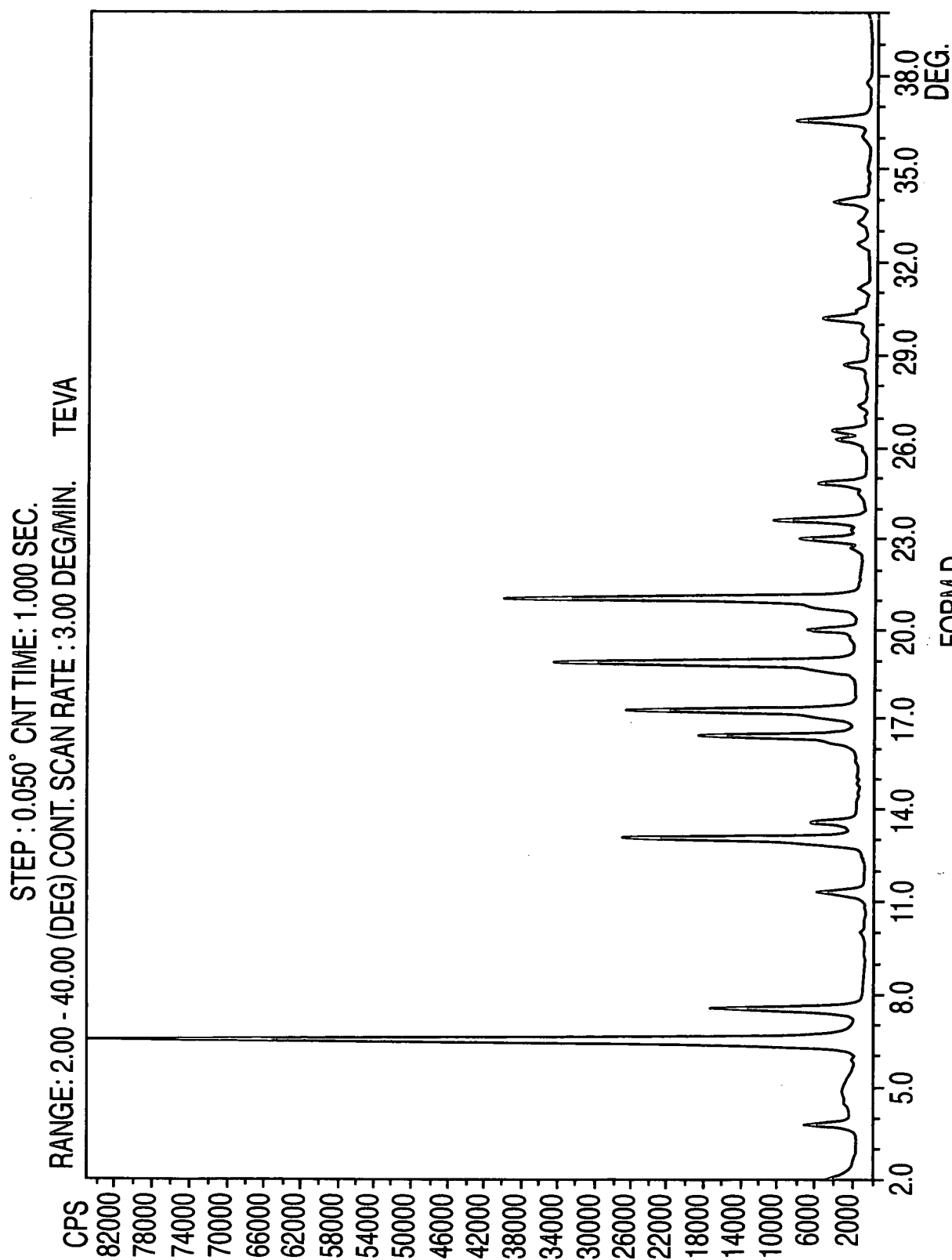
FORMA
FIG. 1

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CNT. SCAN RATE : 3.00 DEG/MIN.

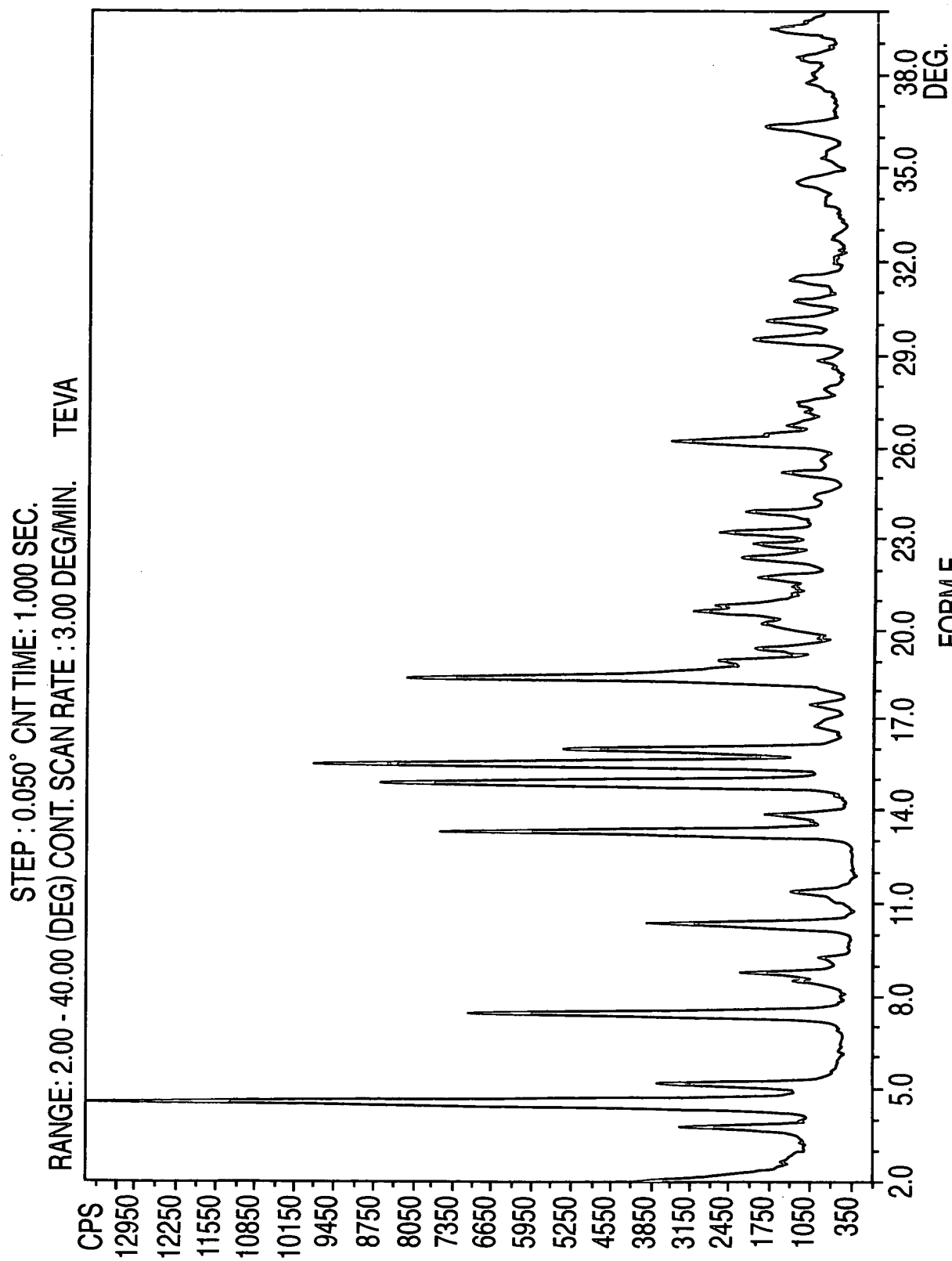


FORM C

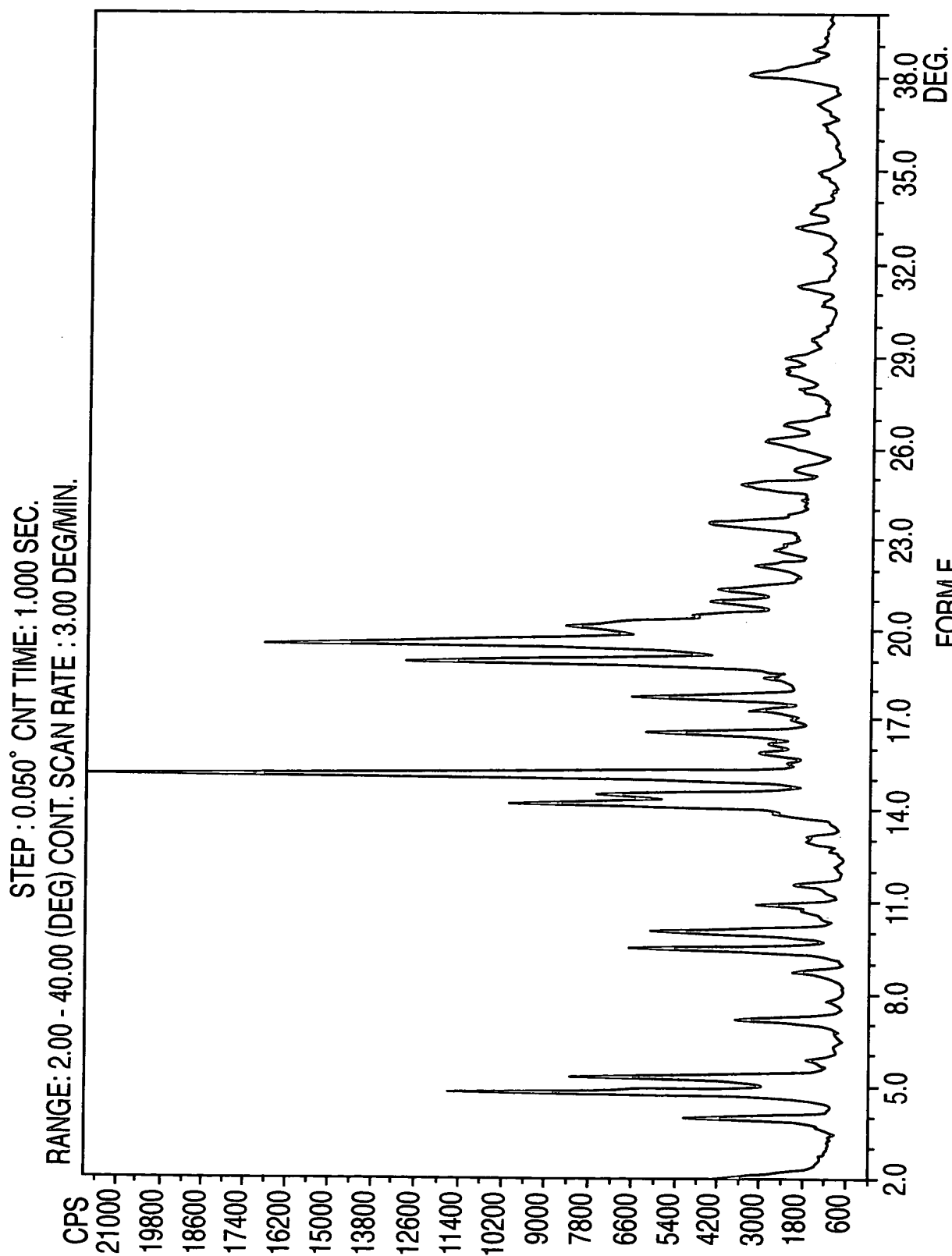
FIG. 2



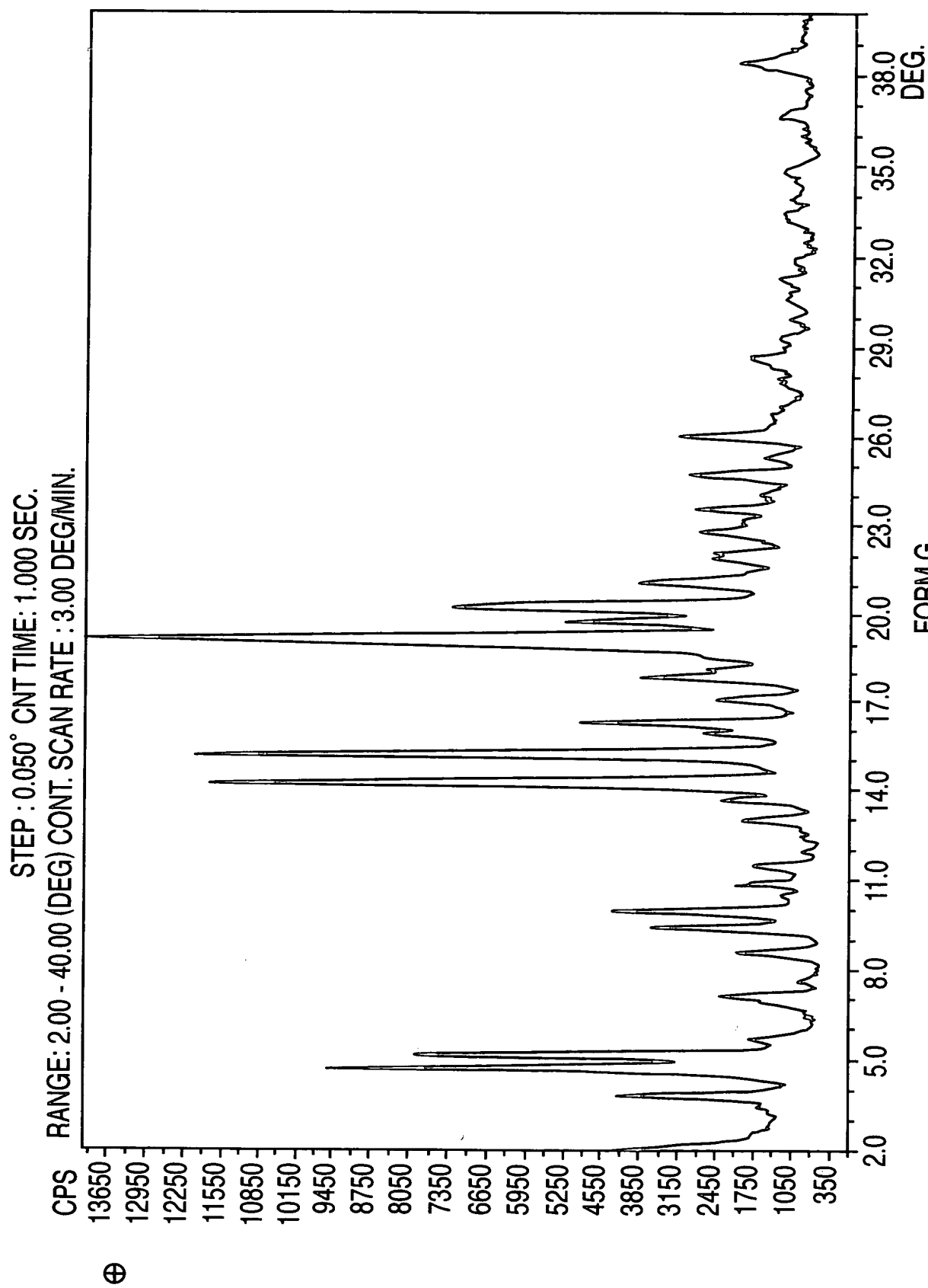
FORM D
FIG. 3



FORM E
FIG. 4

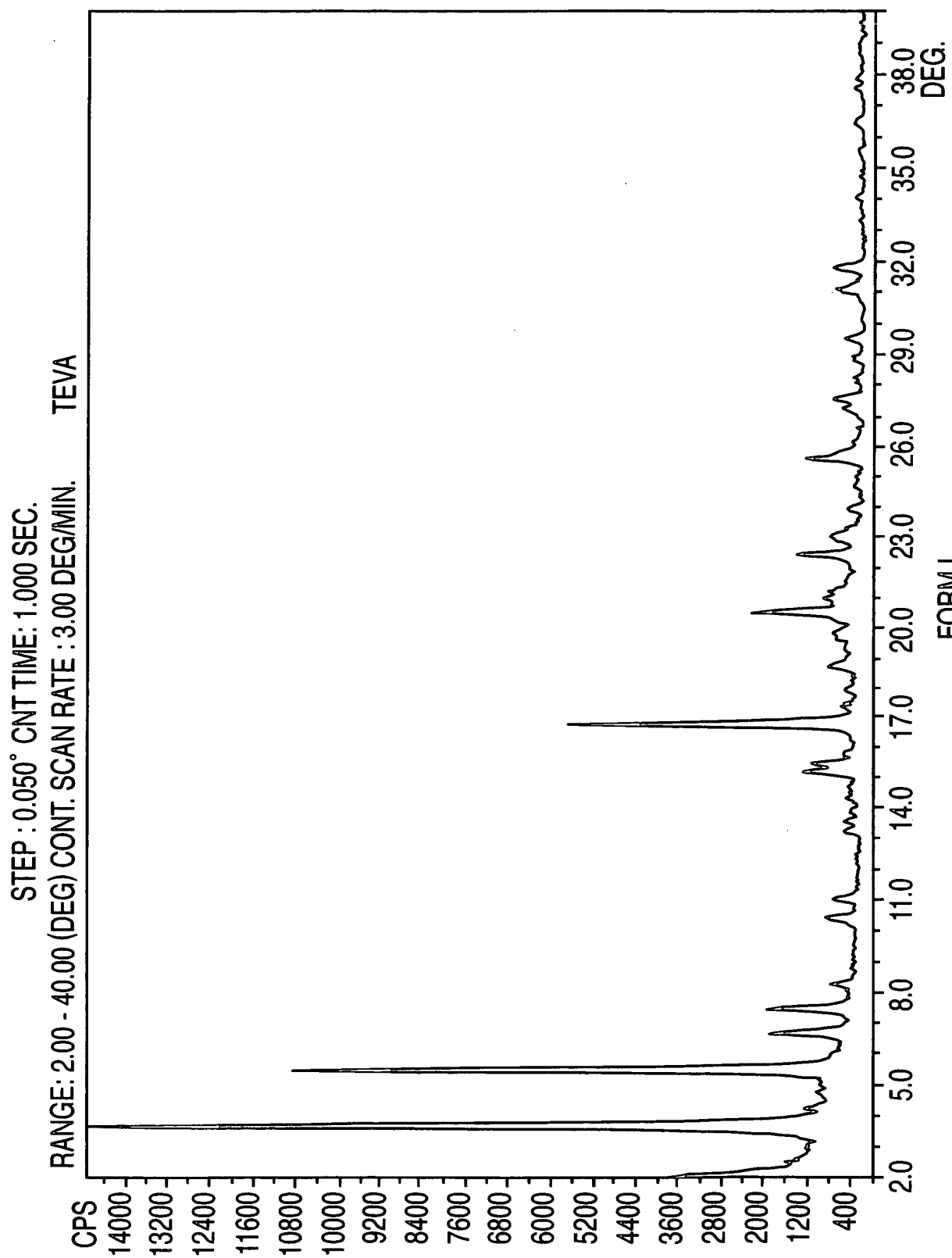


FORM F
FIG. 5

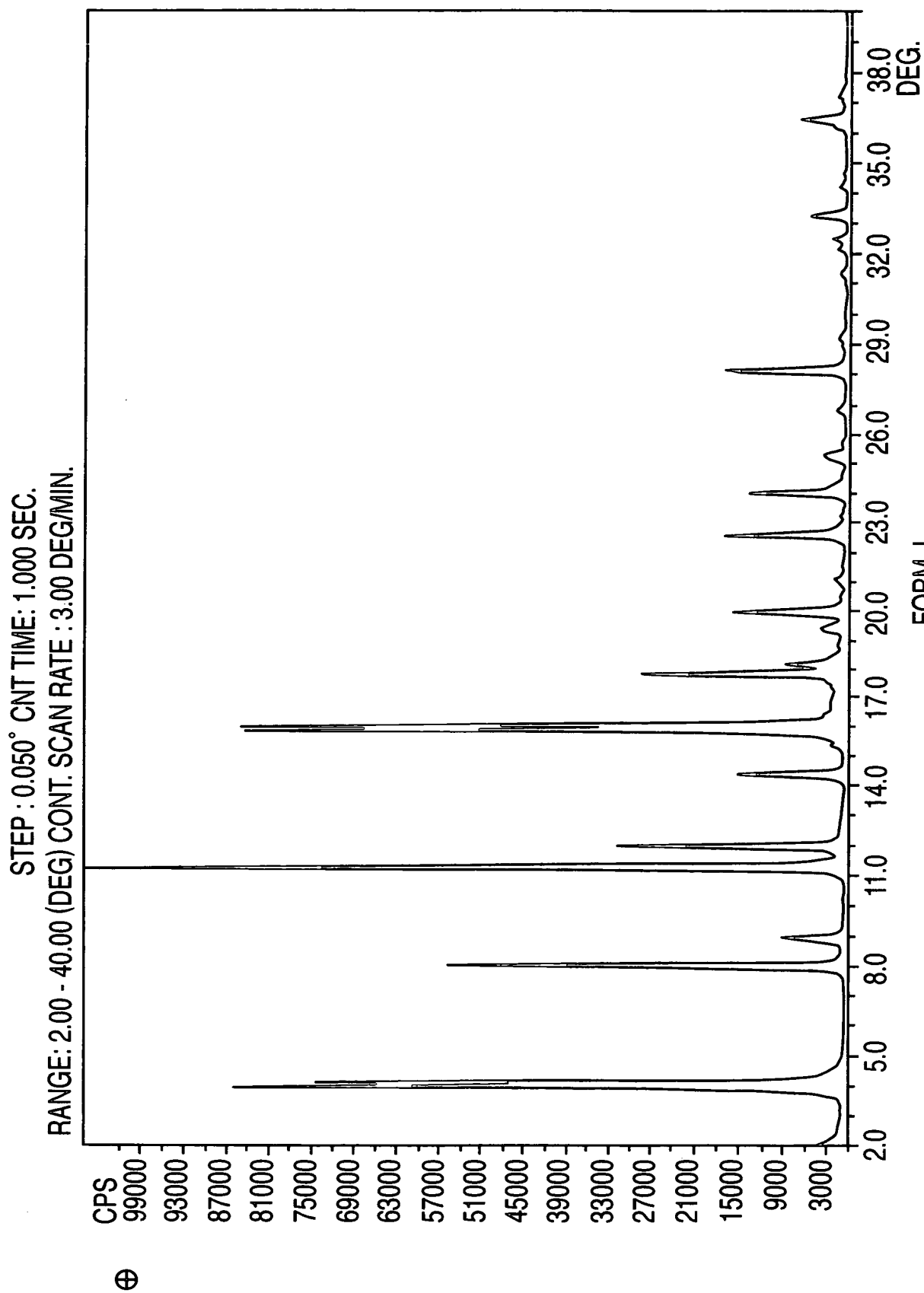


FORM G
FIG. 6

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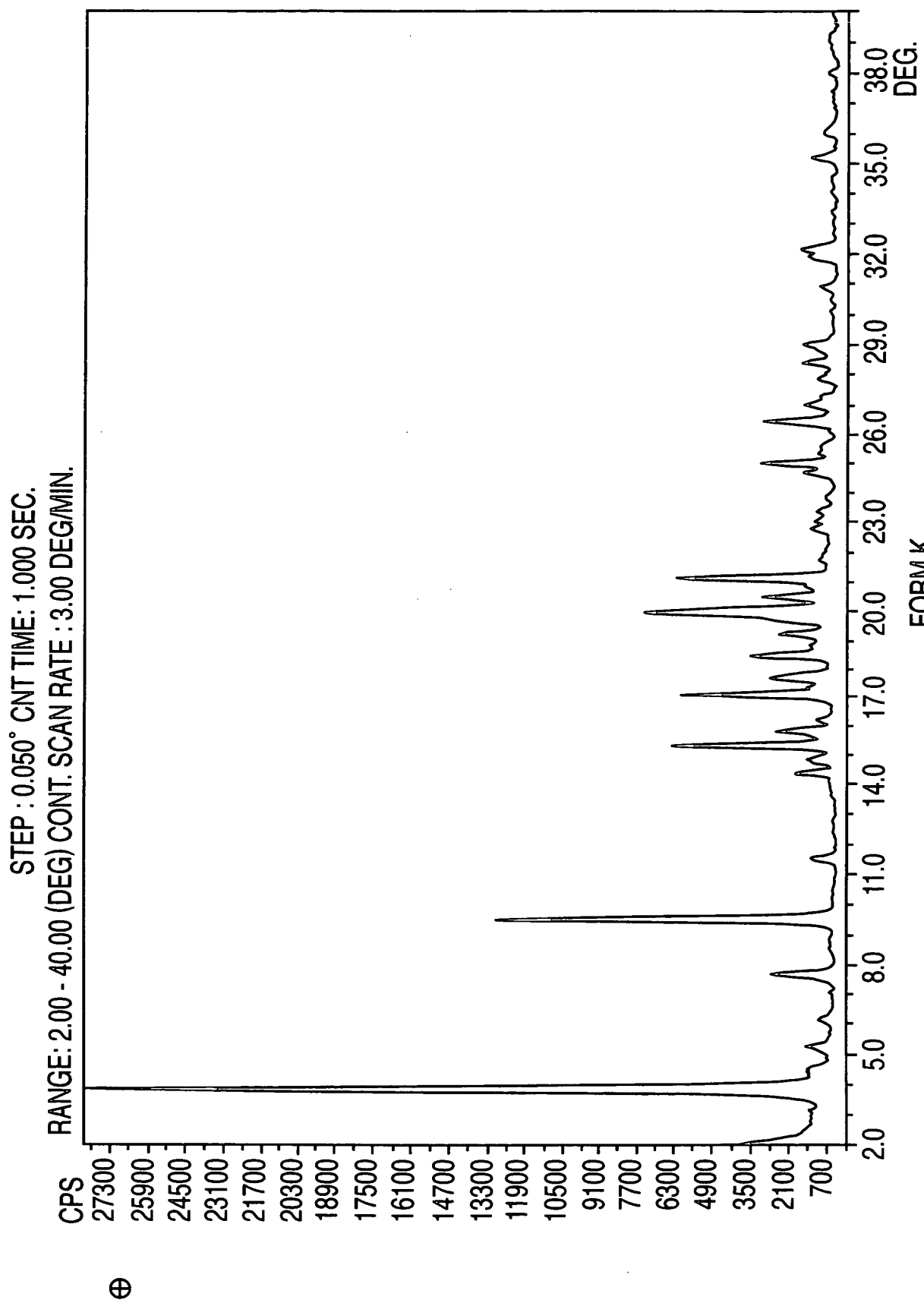


FORM I
FIG. 7

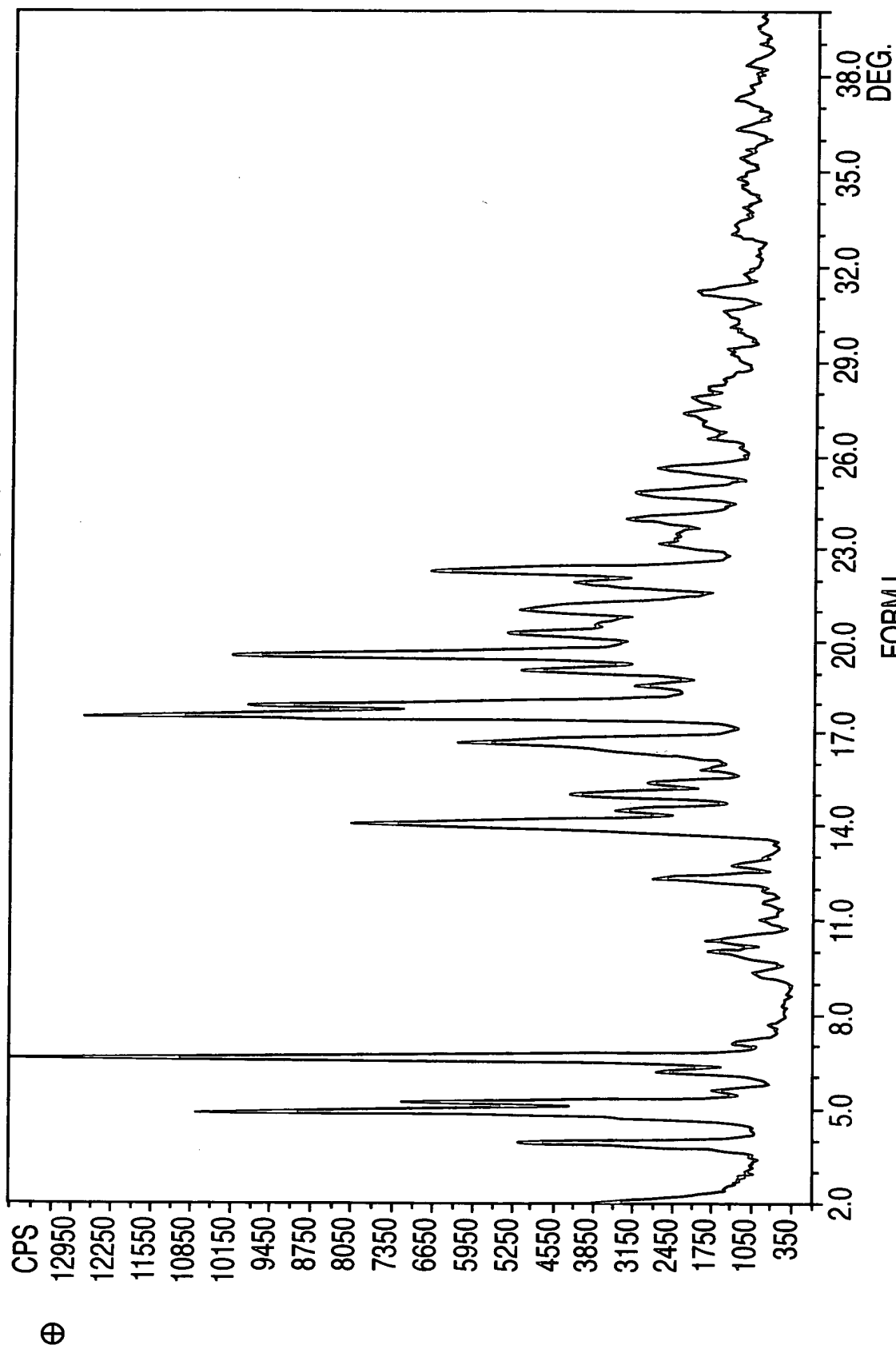


FORM J
FIG. 8

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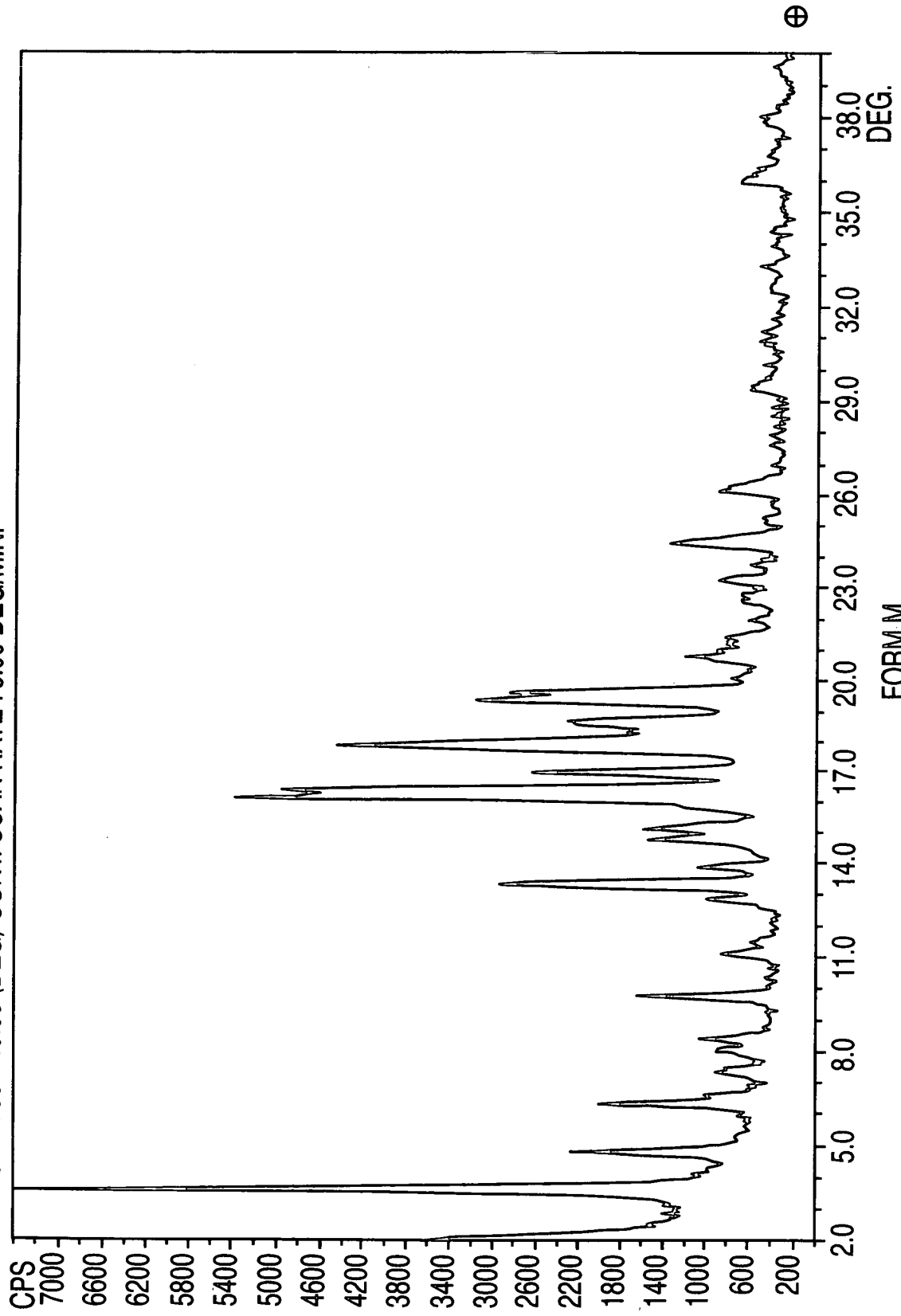
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM L
FIG. 10

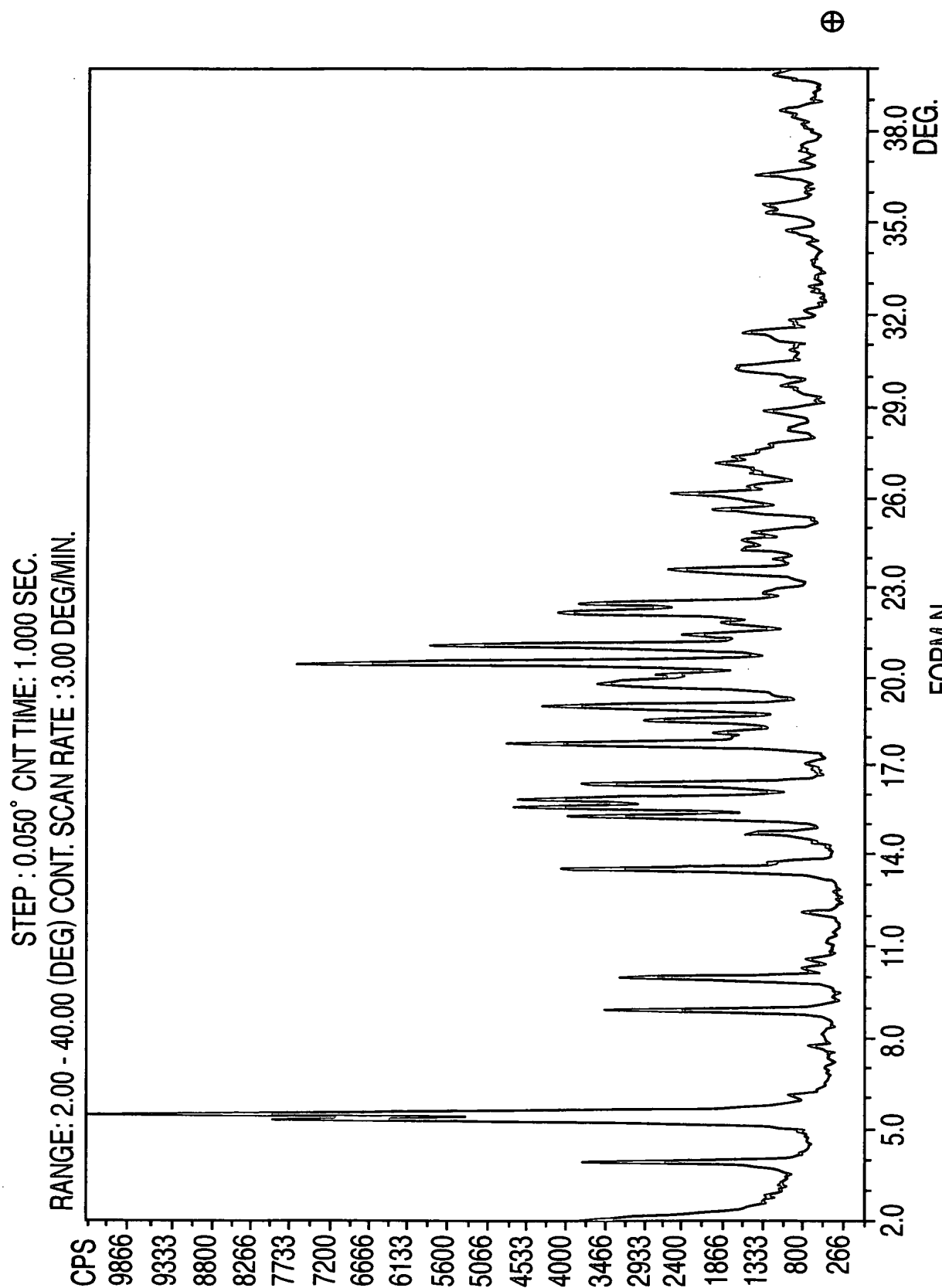
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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



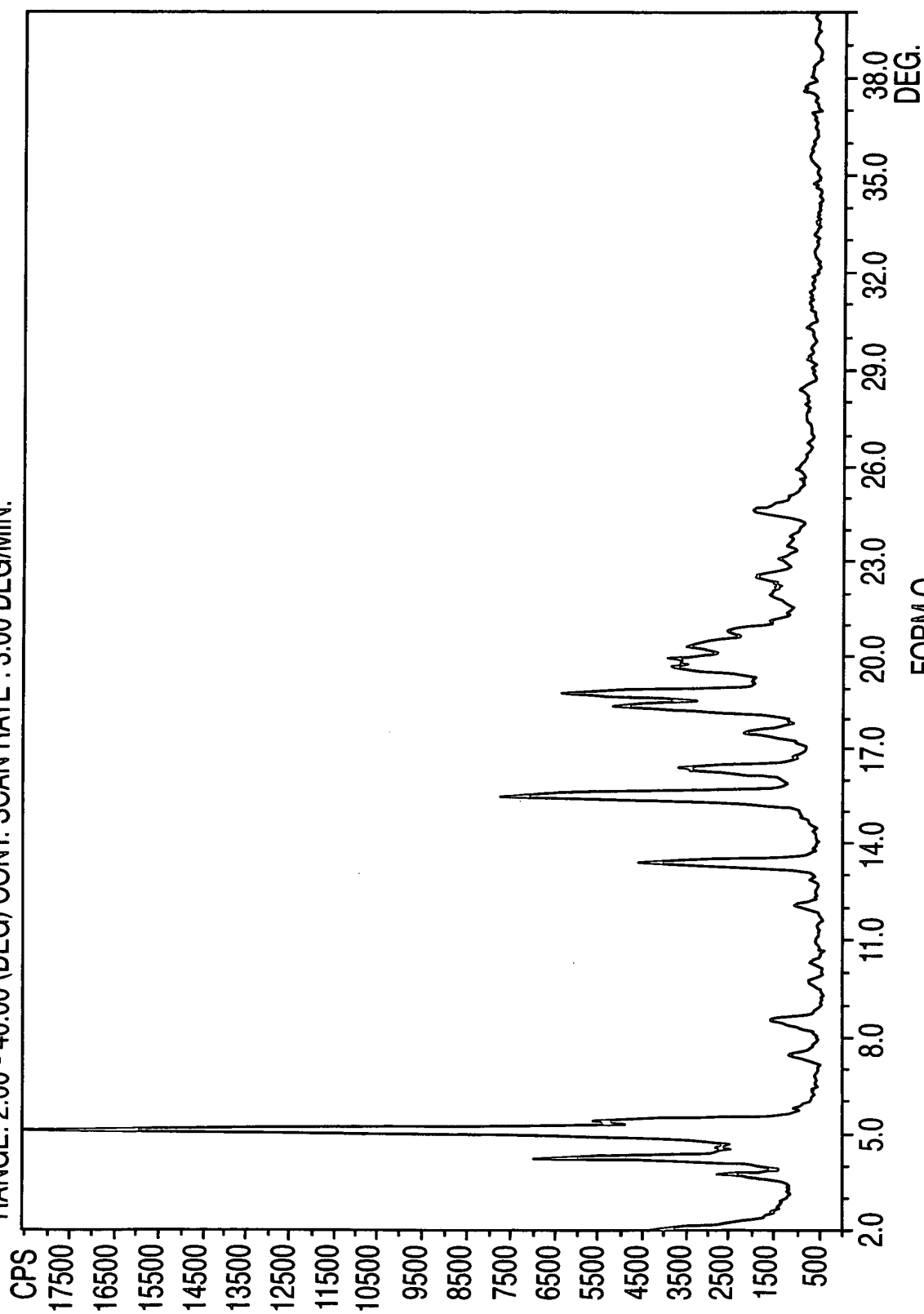
FORM M
FIG. 11

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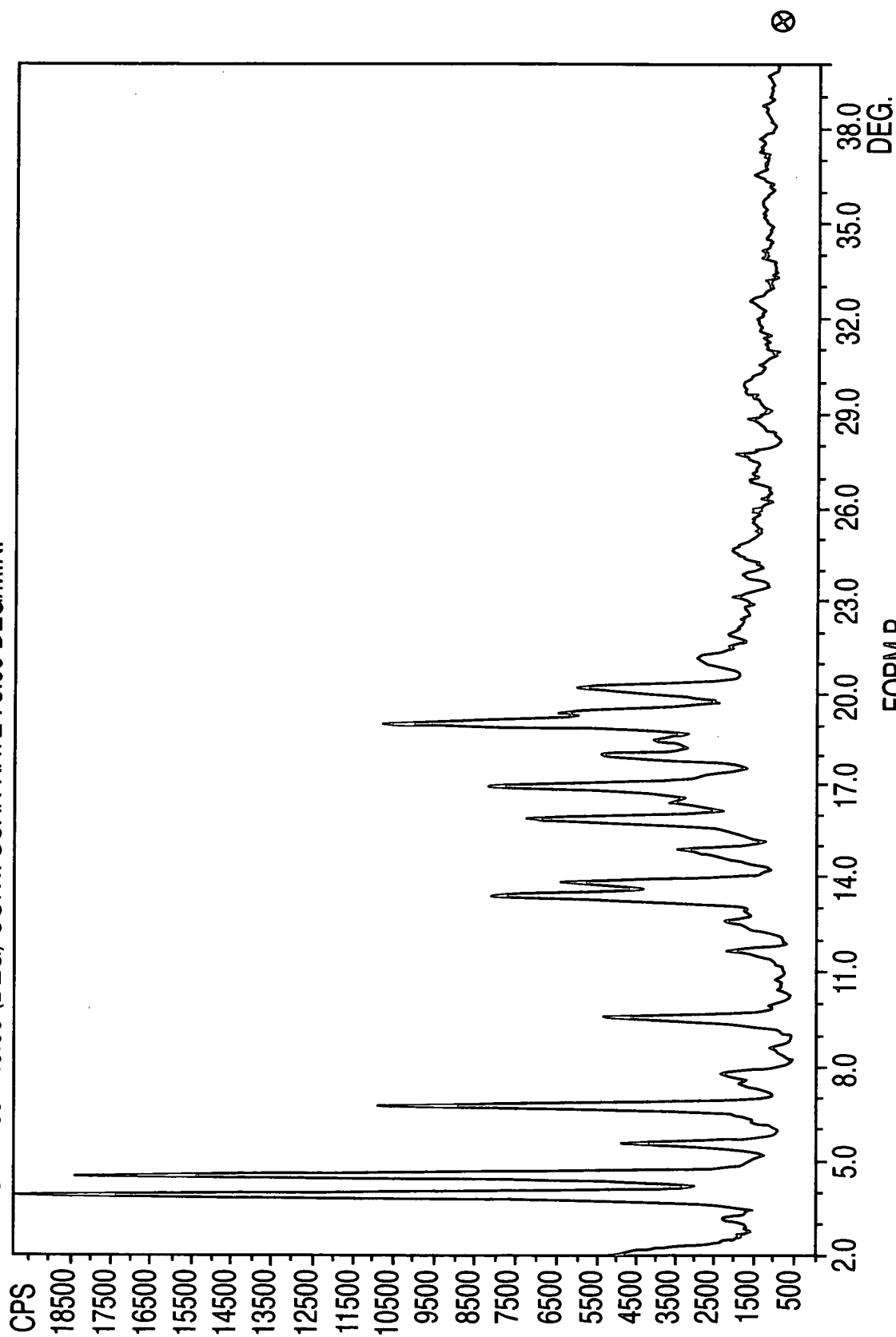
FORM N
FIG. 12

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



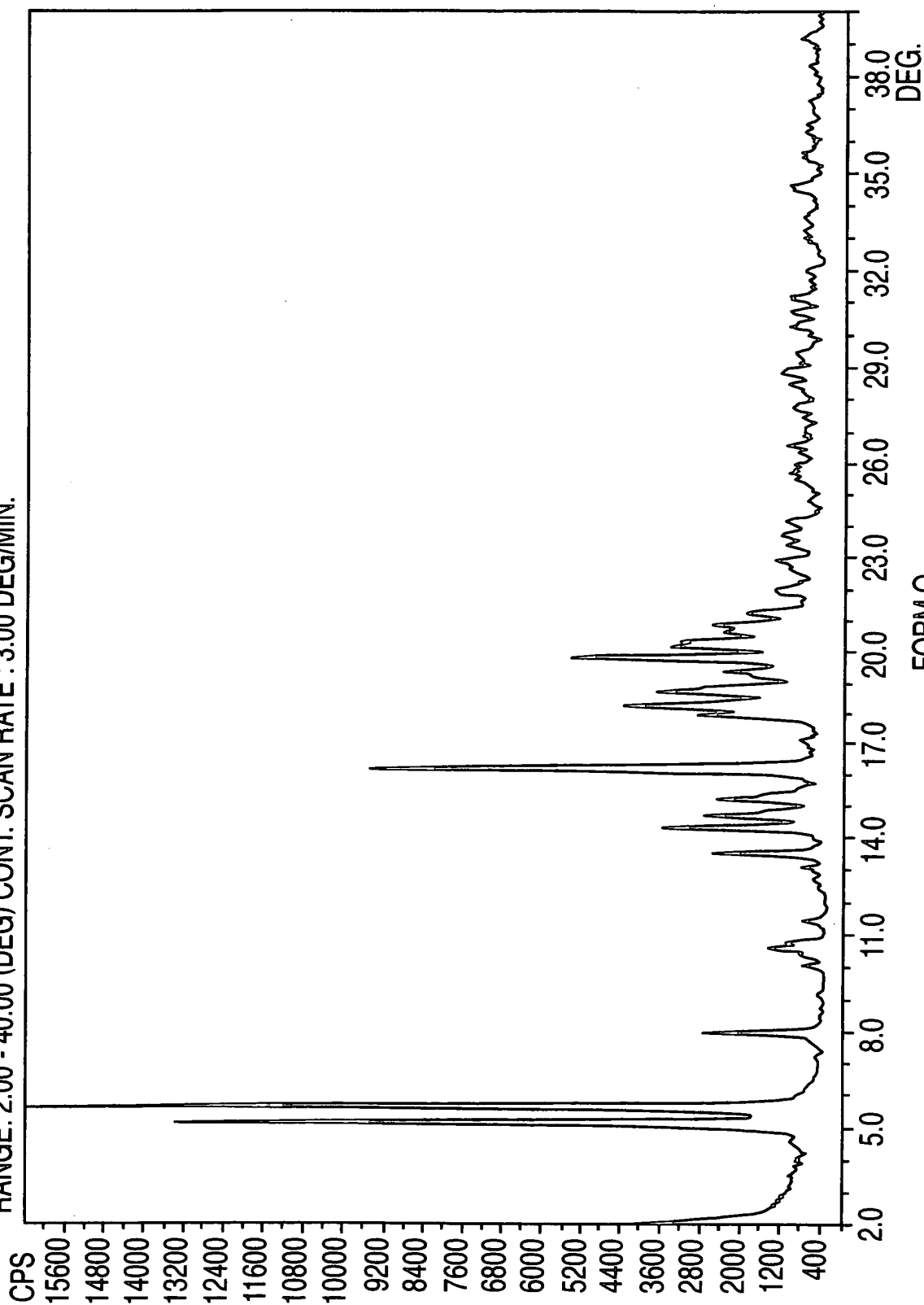
FORM O
FIG. 13

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



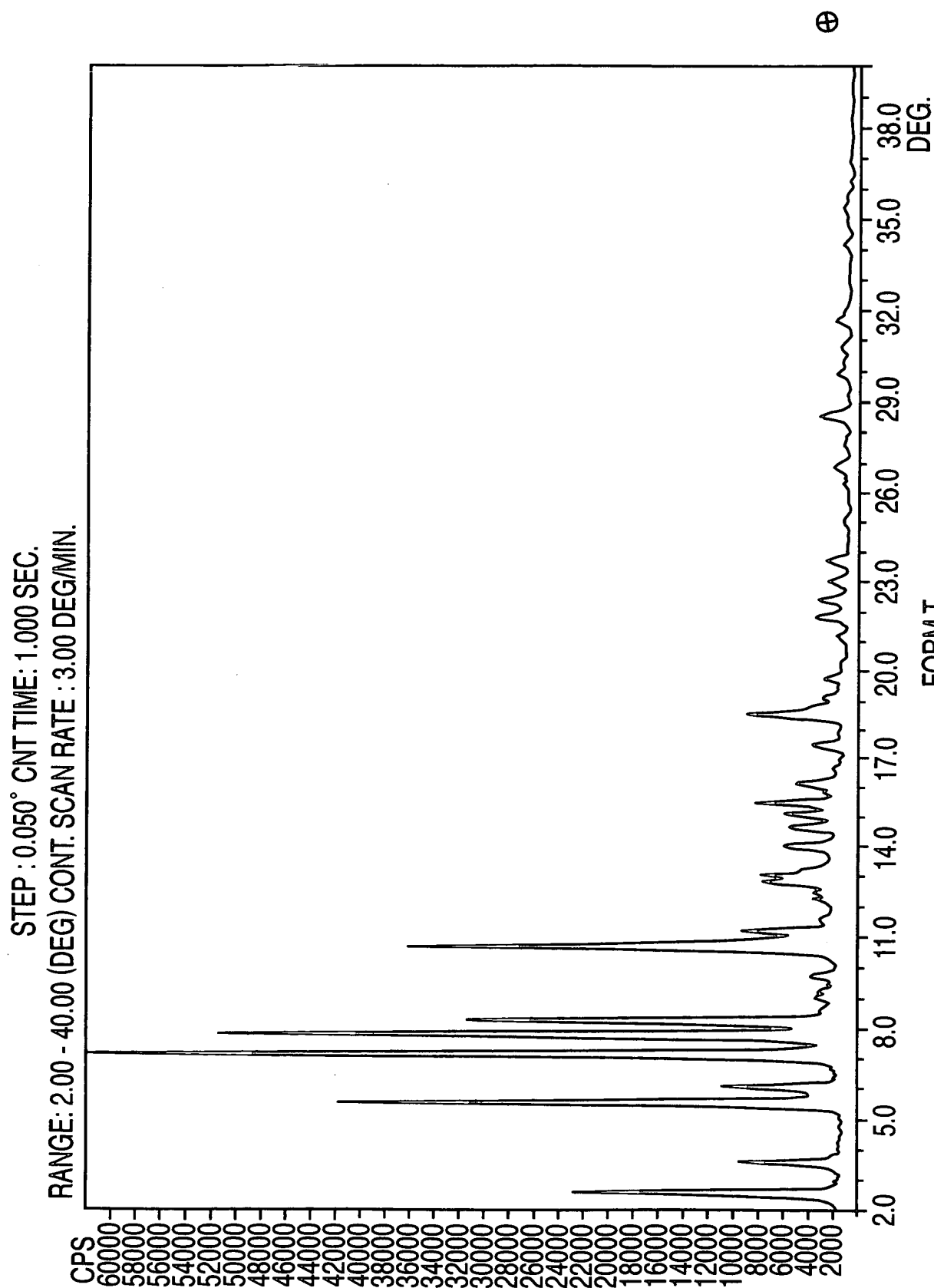
FORM P
FIG. 14

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



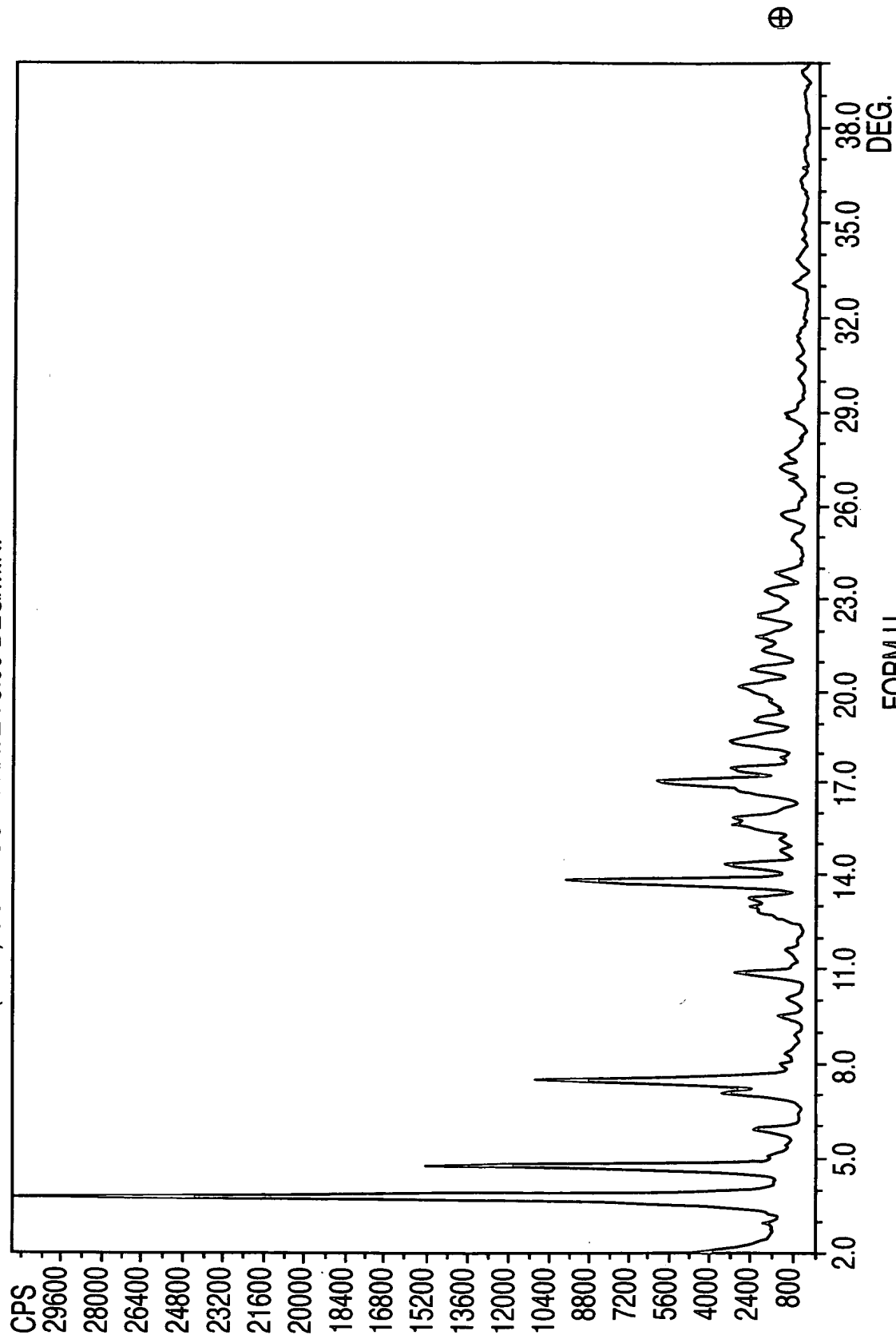
FORM Q
FIG. 15

⊗



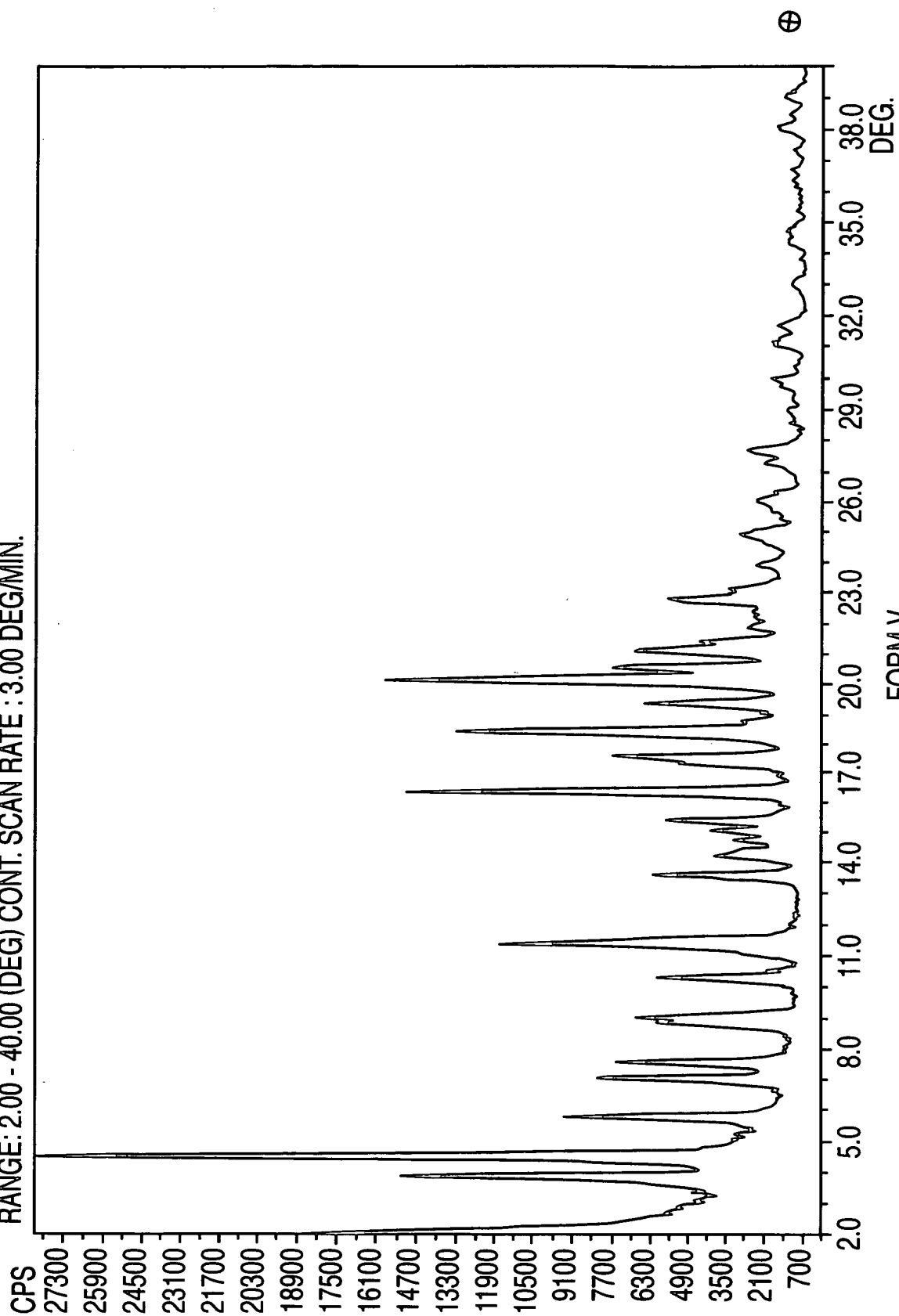
FORM T
FIG. 16

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



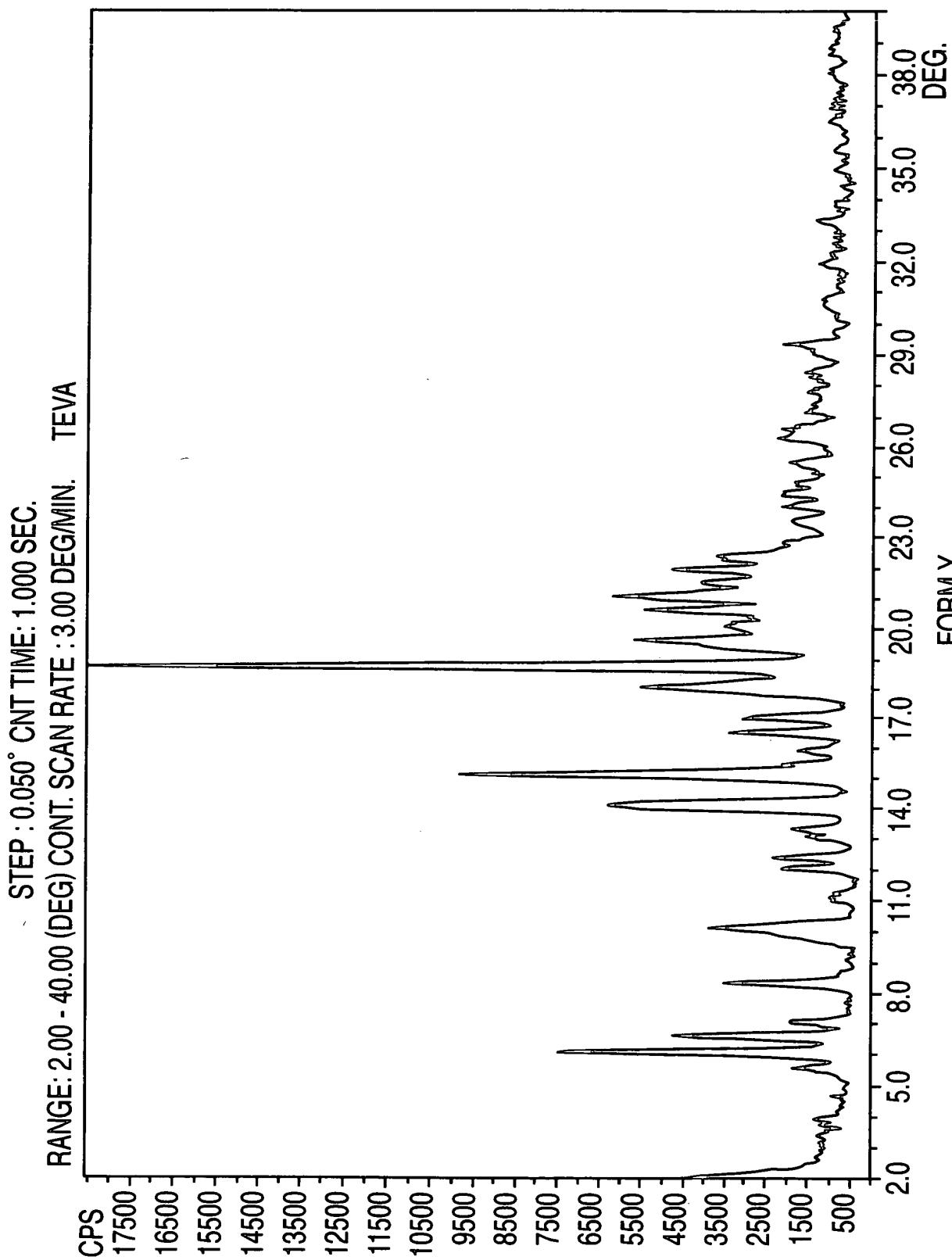
FORM U
FIG. 17

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



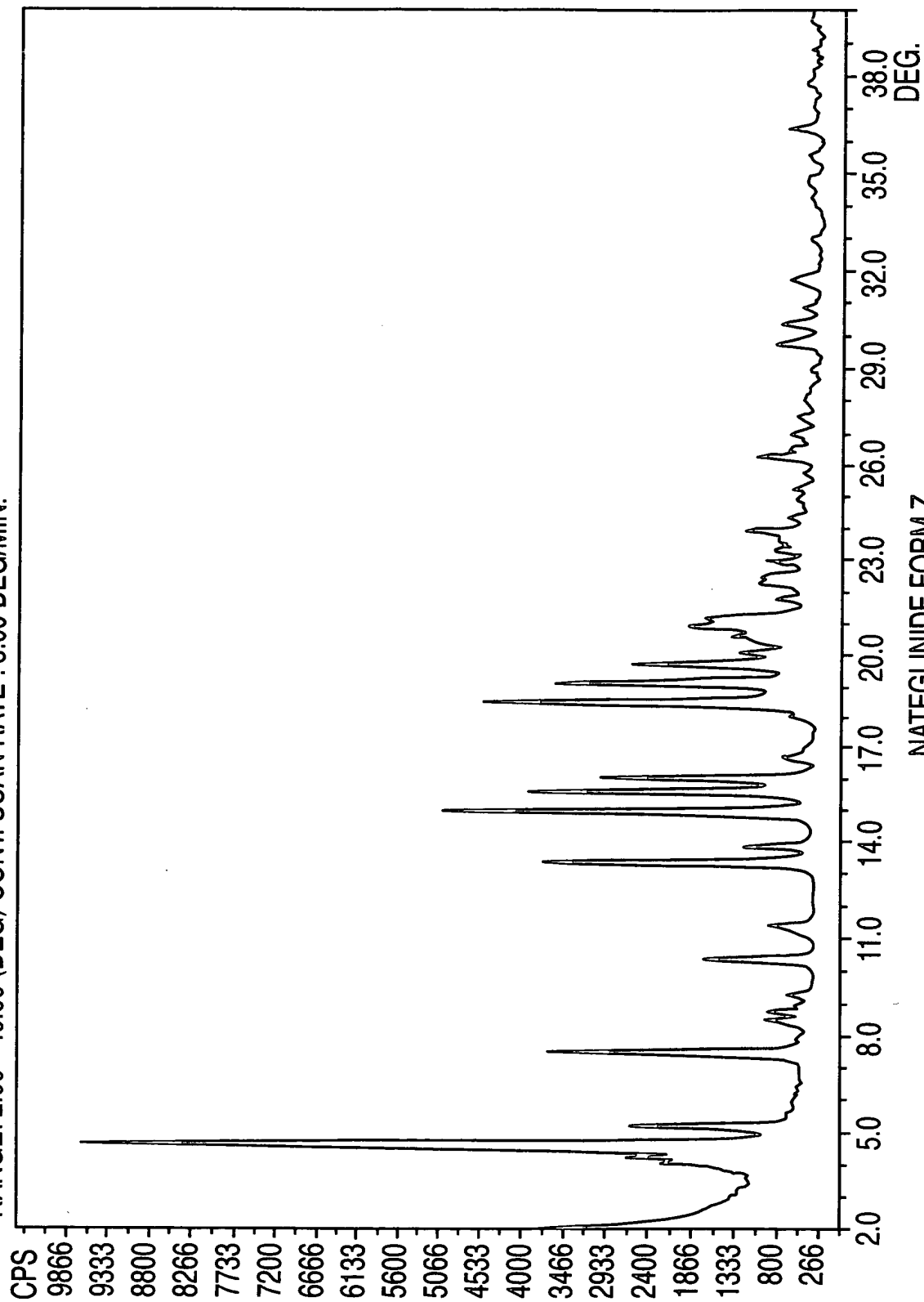
FORM V
FIG. 18

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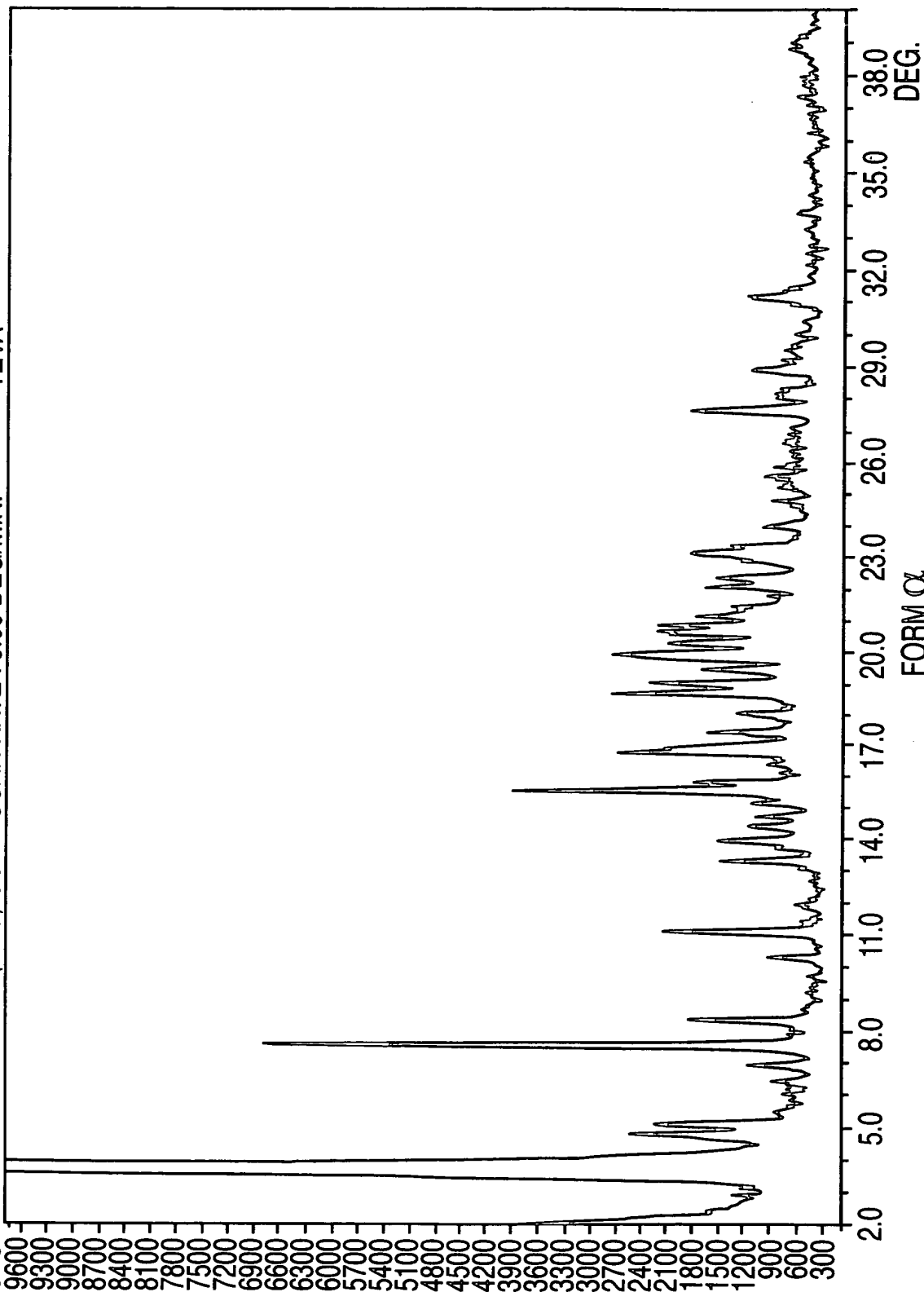
FORM Y
FIG. 19

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



NATEGLINIDE FORM Z
FIG. 20

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM α
FIG. 21

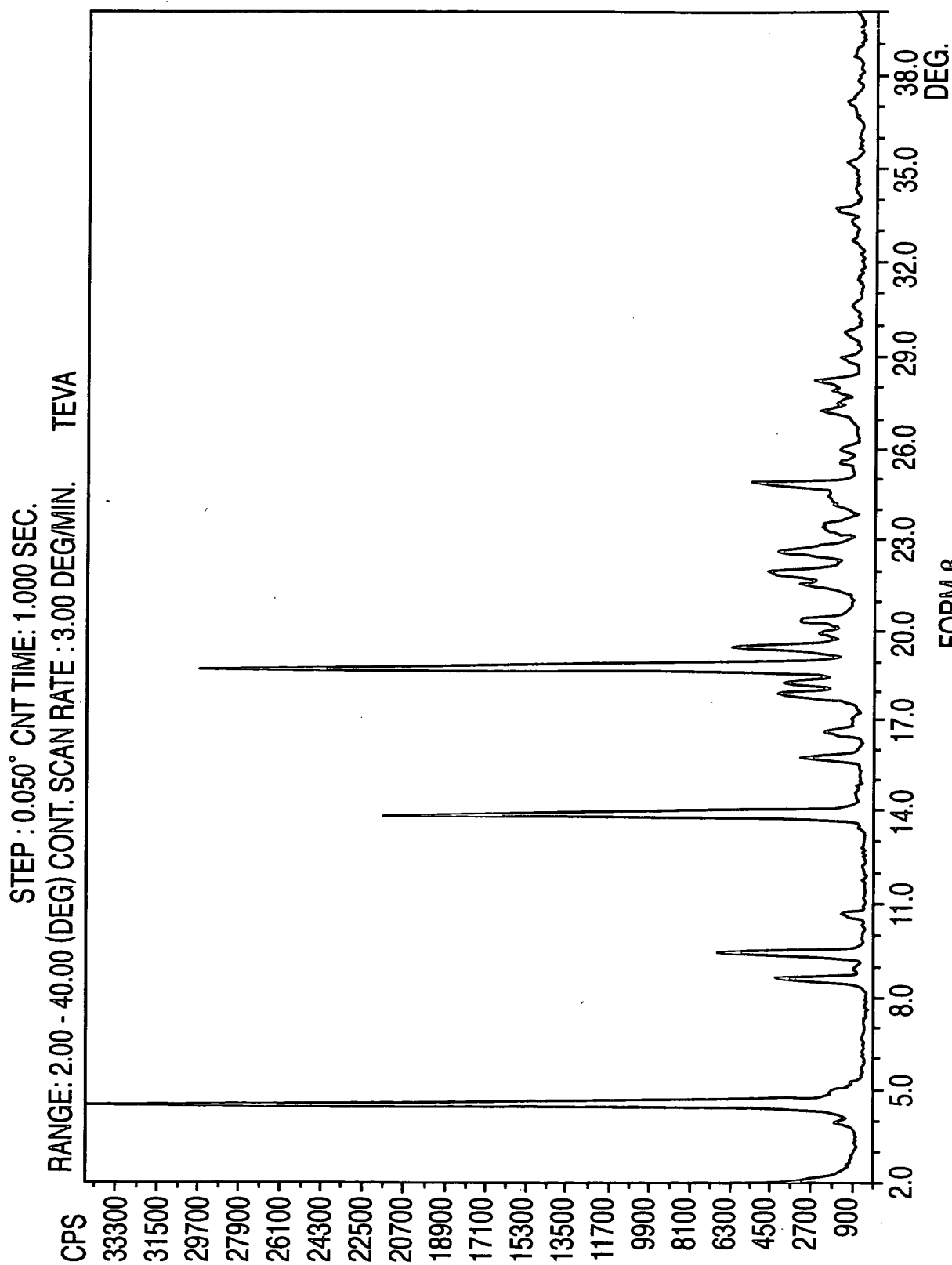
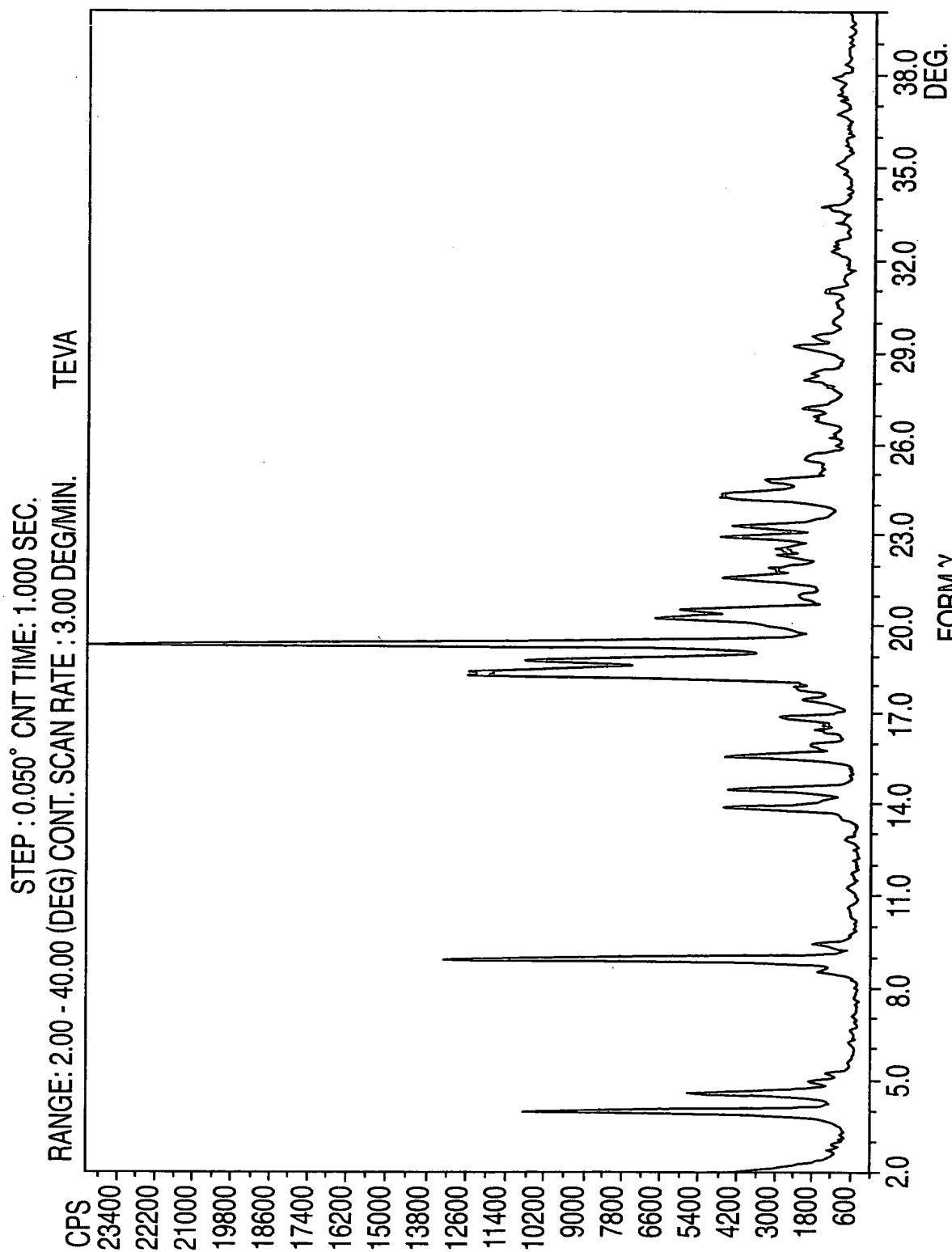
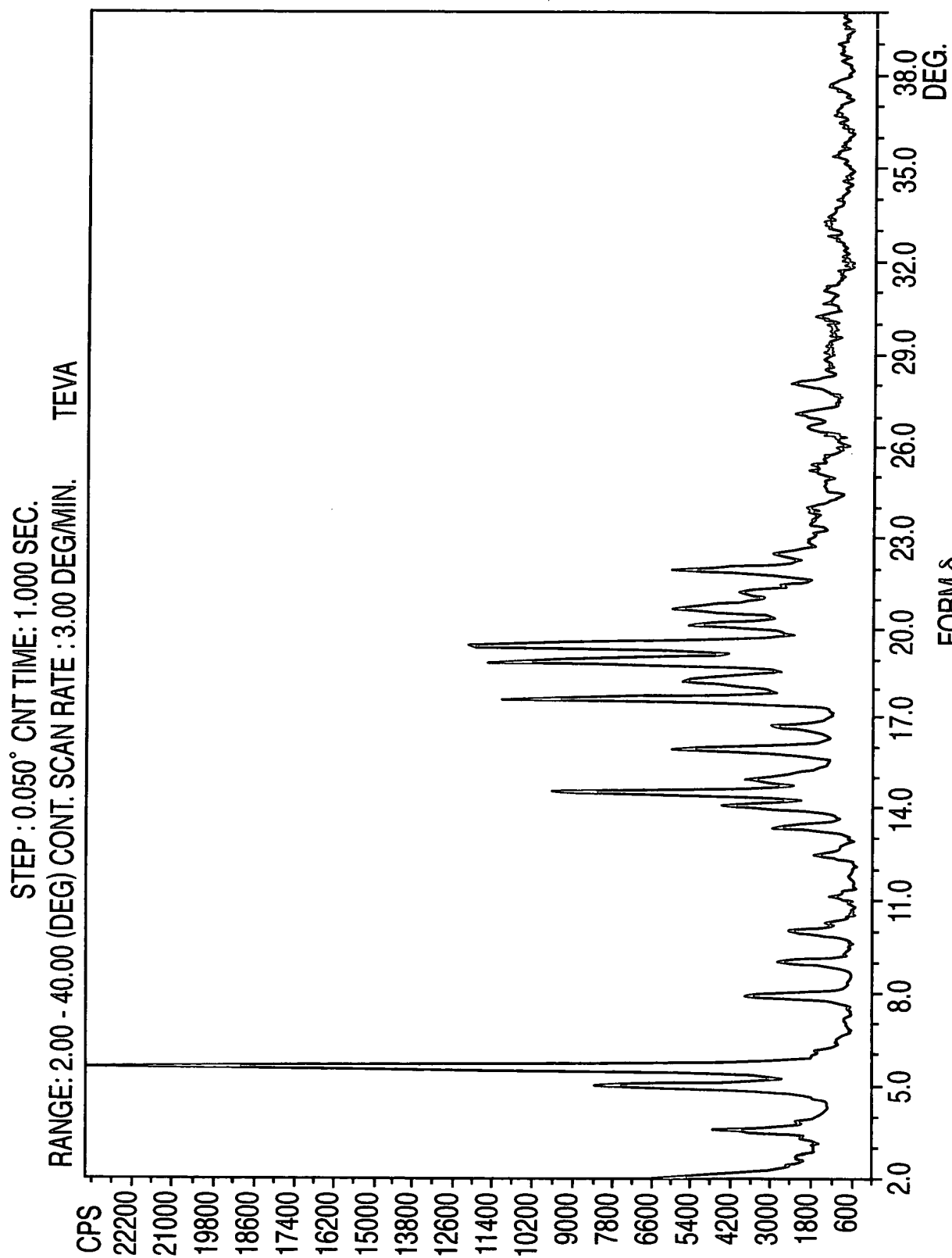


FIG. 22



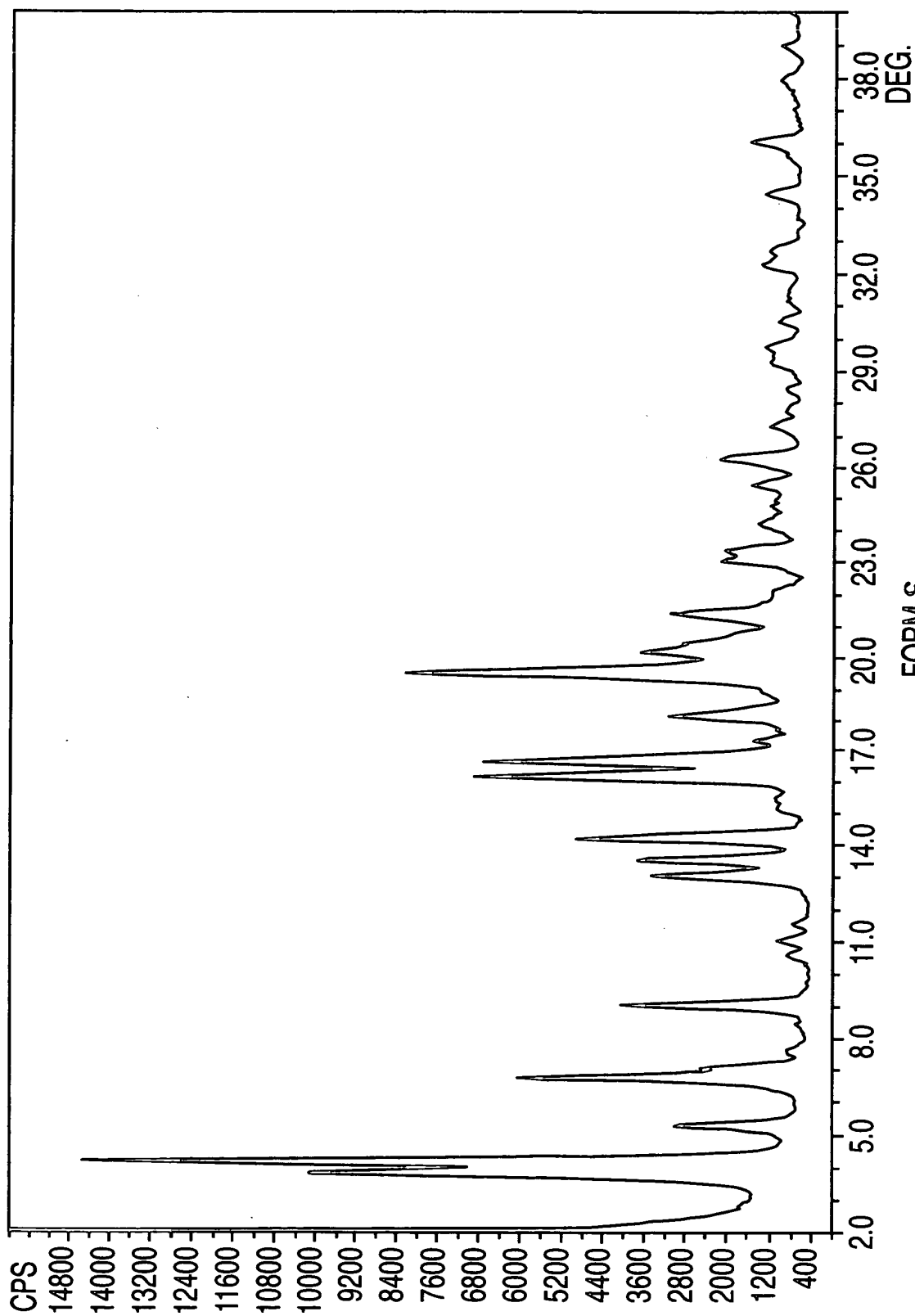
FORM Y

FIG. 23

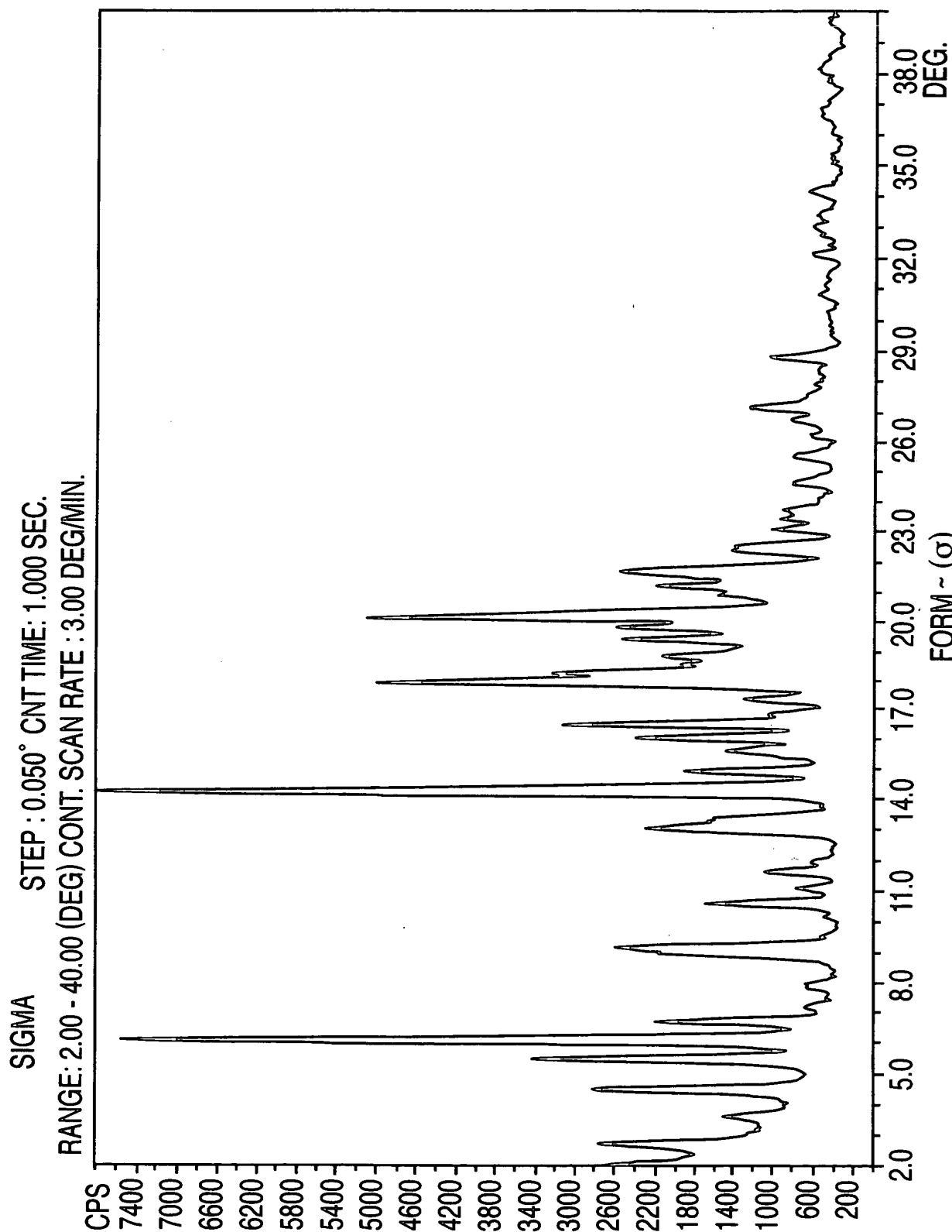


FORM 8
FIG. 24

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CNT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM E
FIG. 25



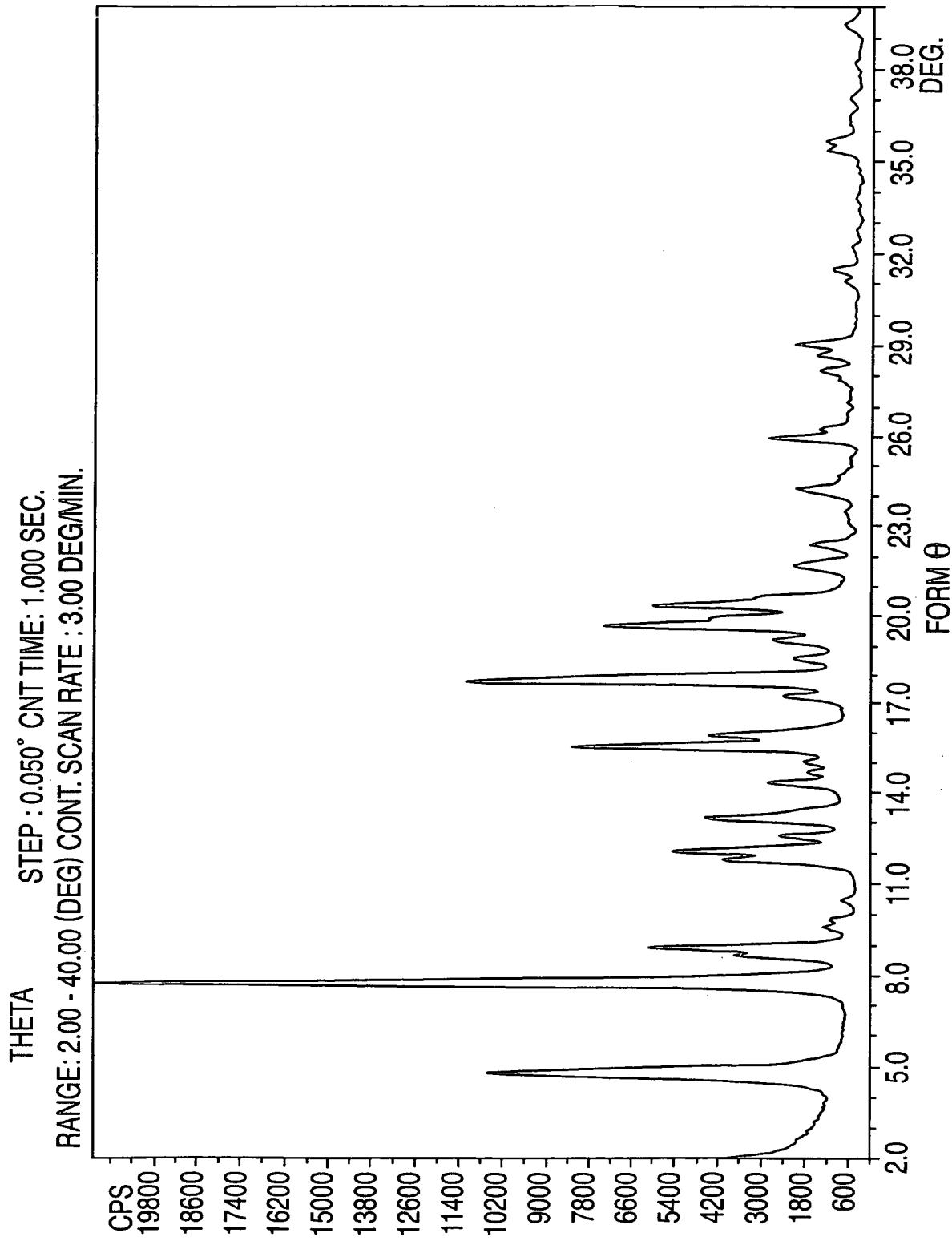
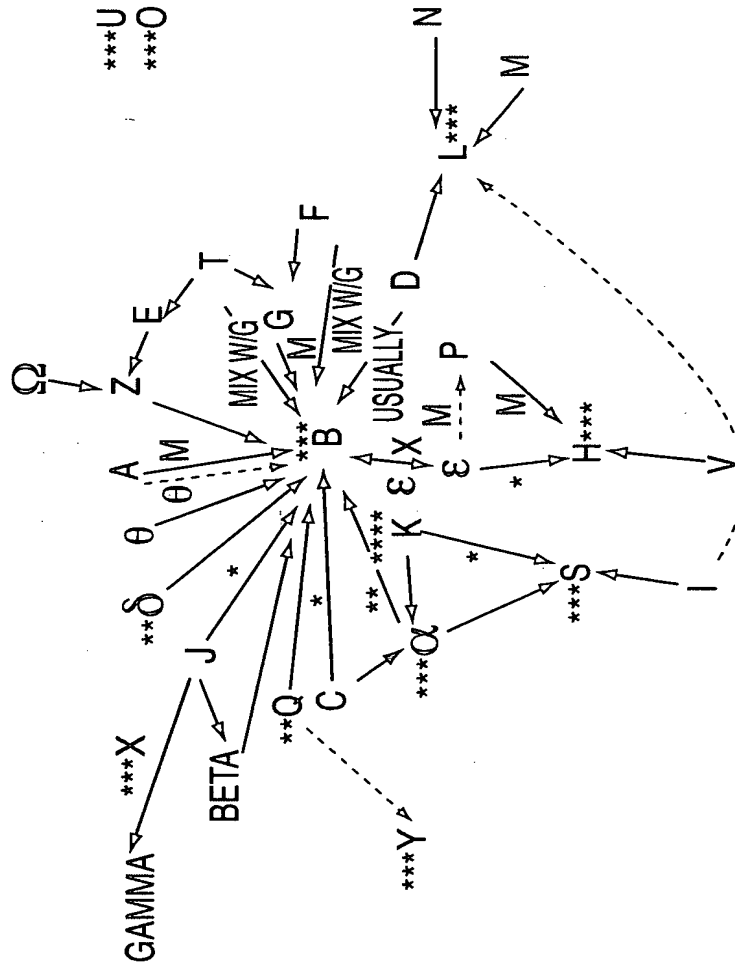


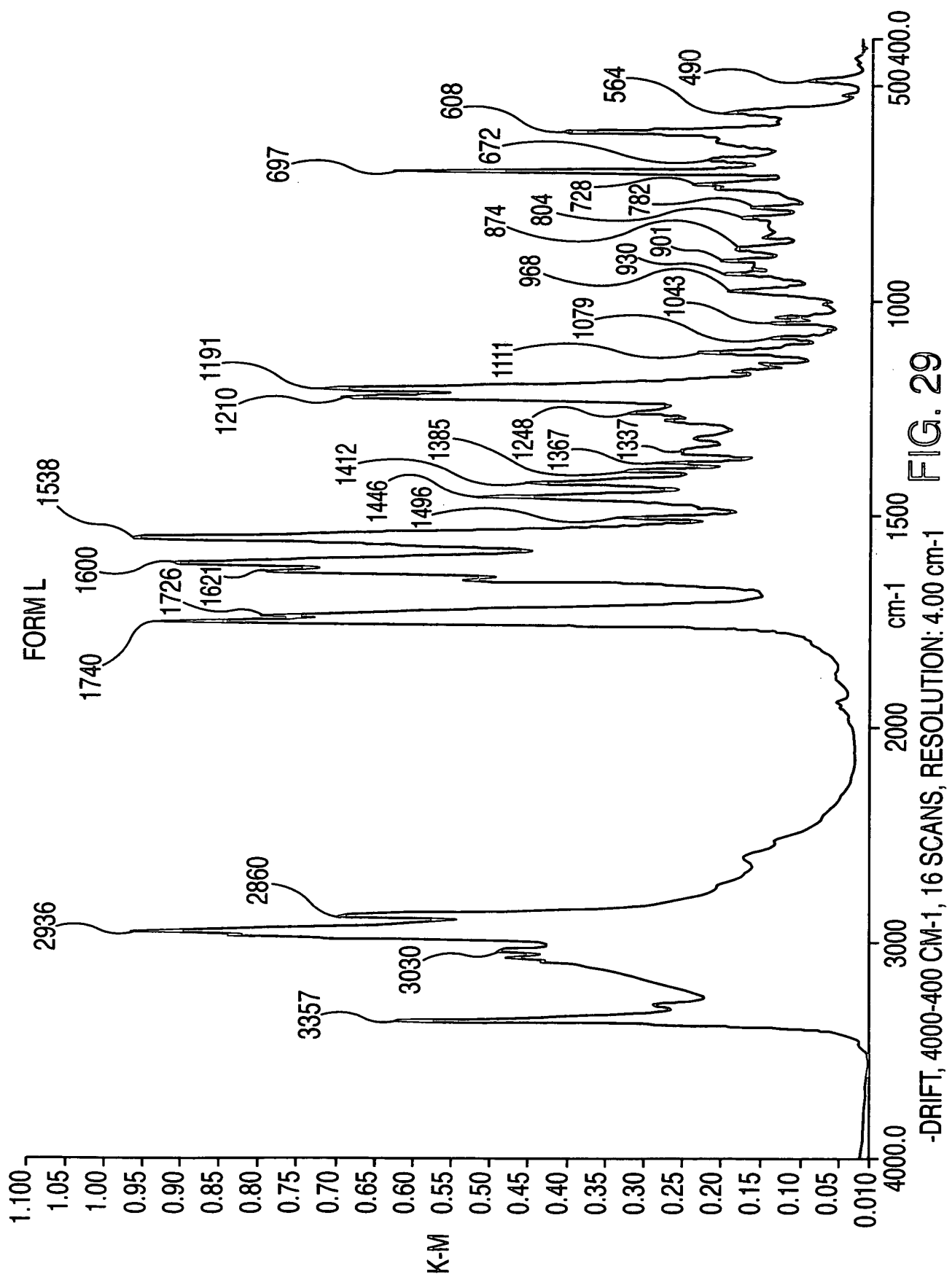
FIG. 27

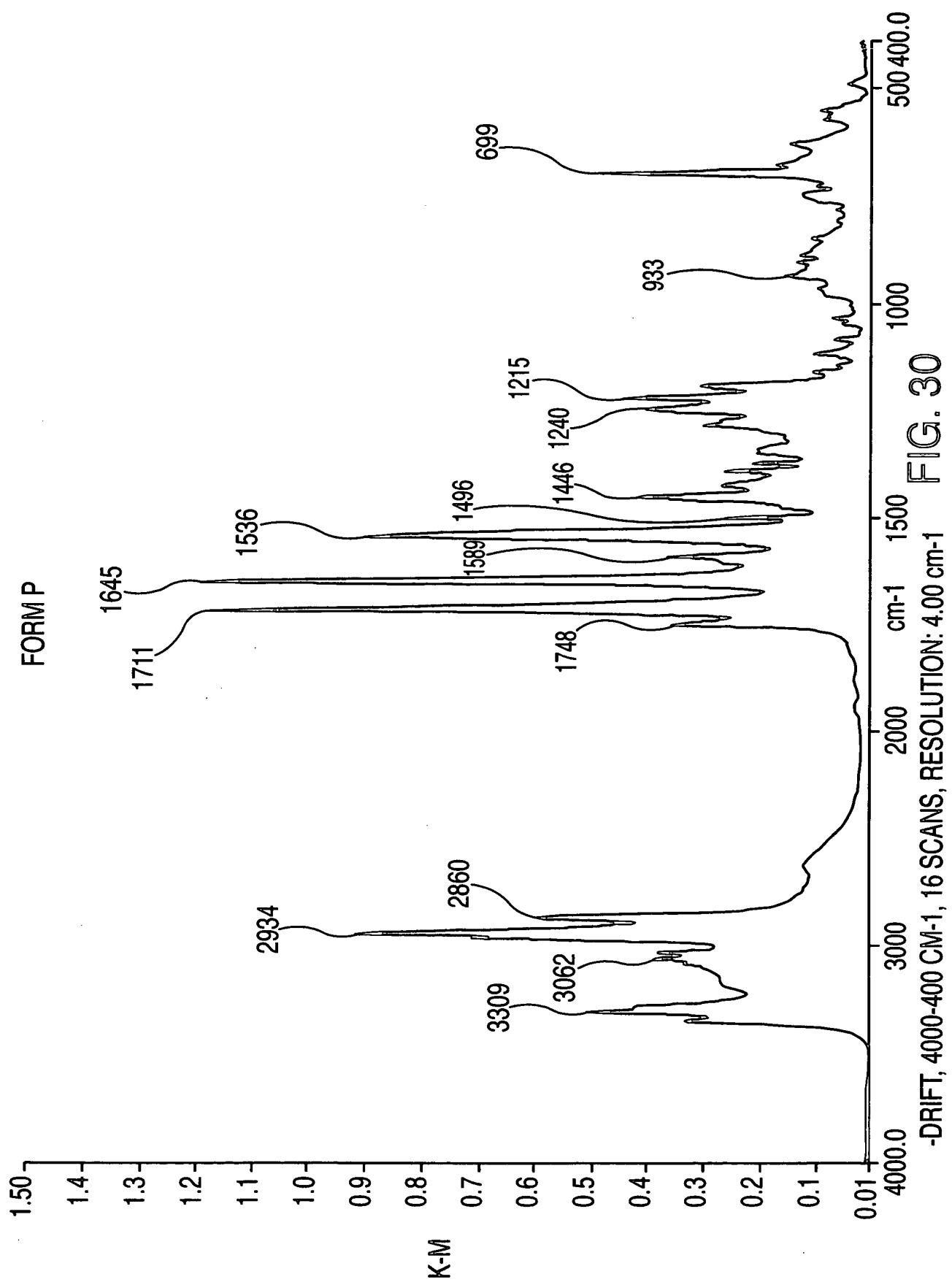


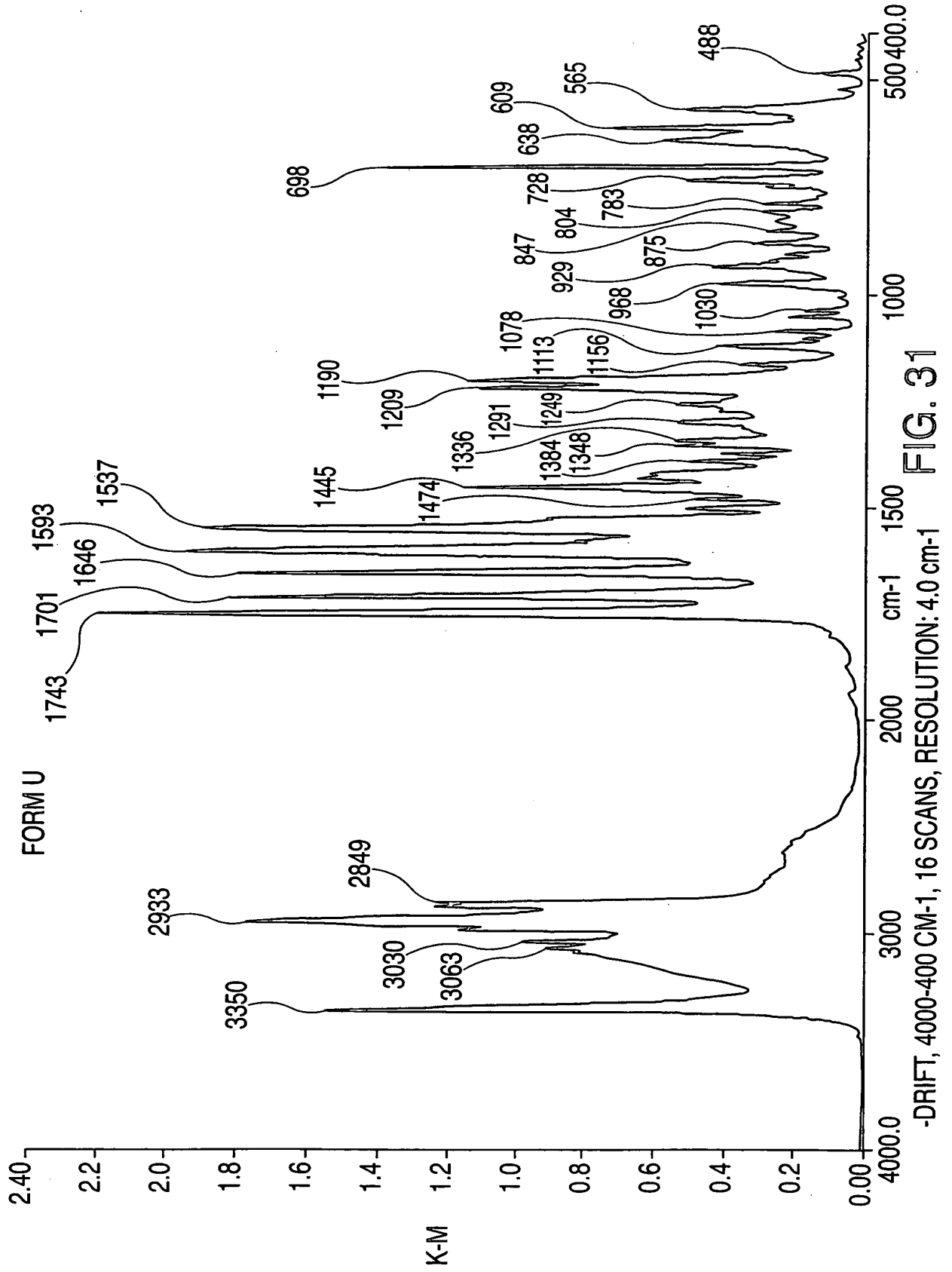
- * TRANSFORMATION MAY PROCEED THROUGH ANOTHER TERM.
- ** THERMALLY STABLE AT LOWER HEATING TEMPERATURES (~50°C).
- *** THERMALLY STABLE FORMS.
- > TRANSFORMATION AFTER STORAGE AT ROOM TEMPERATURE.
- m MIXTURE WITH STARTING FORM.
- **** WHEN STARTING MATERIAL CONTAINS SEEDS.
- sol RESULTS MIGHT VARY DEPENDING ON THE SOLVATE OF FORM EPSILON USED.

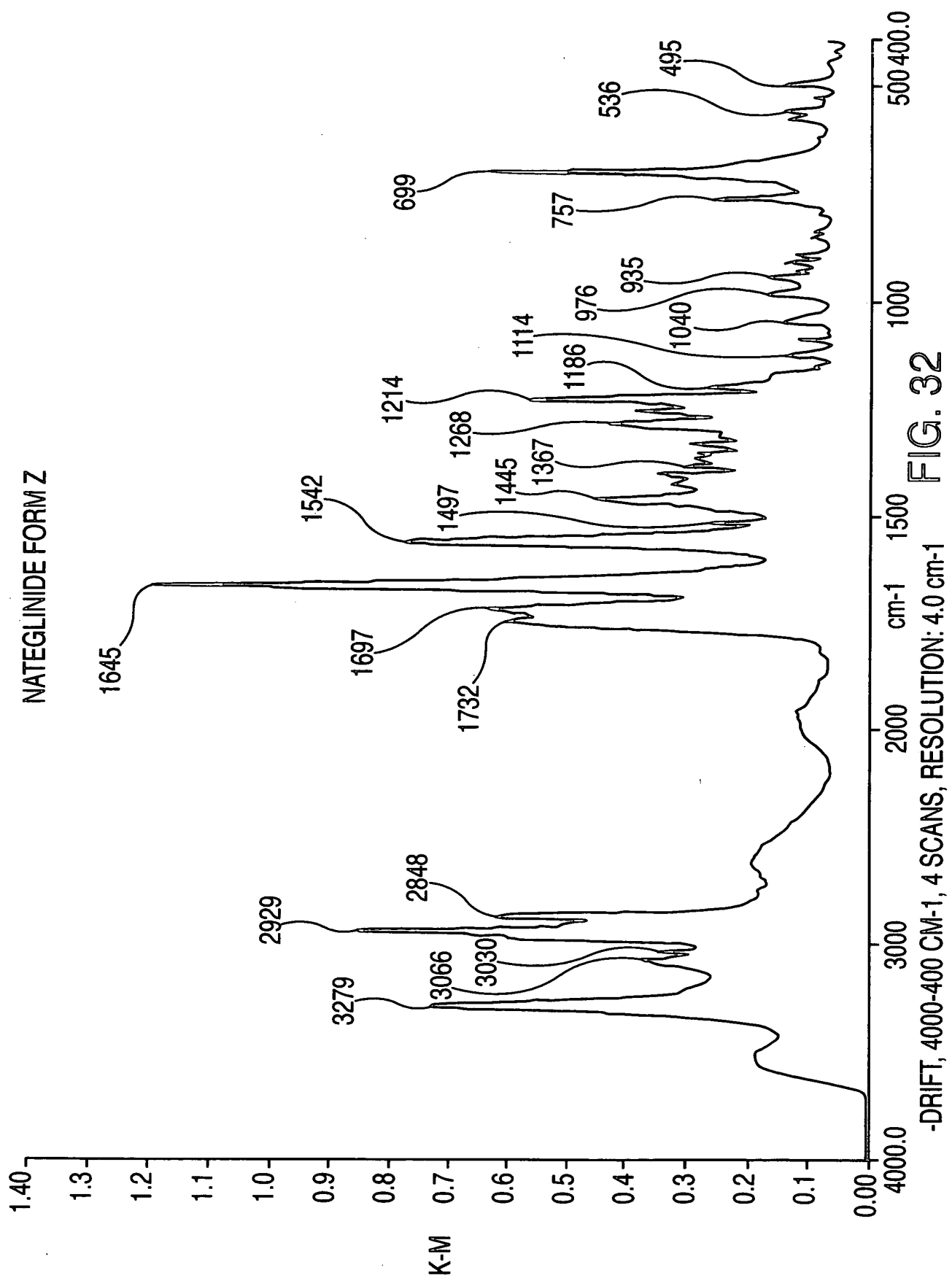
THERMAL STABILITY CHART

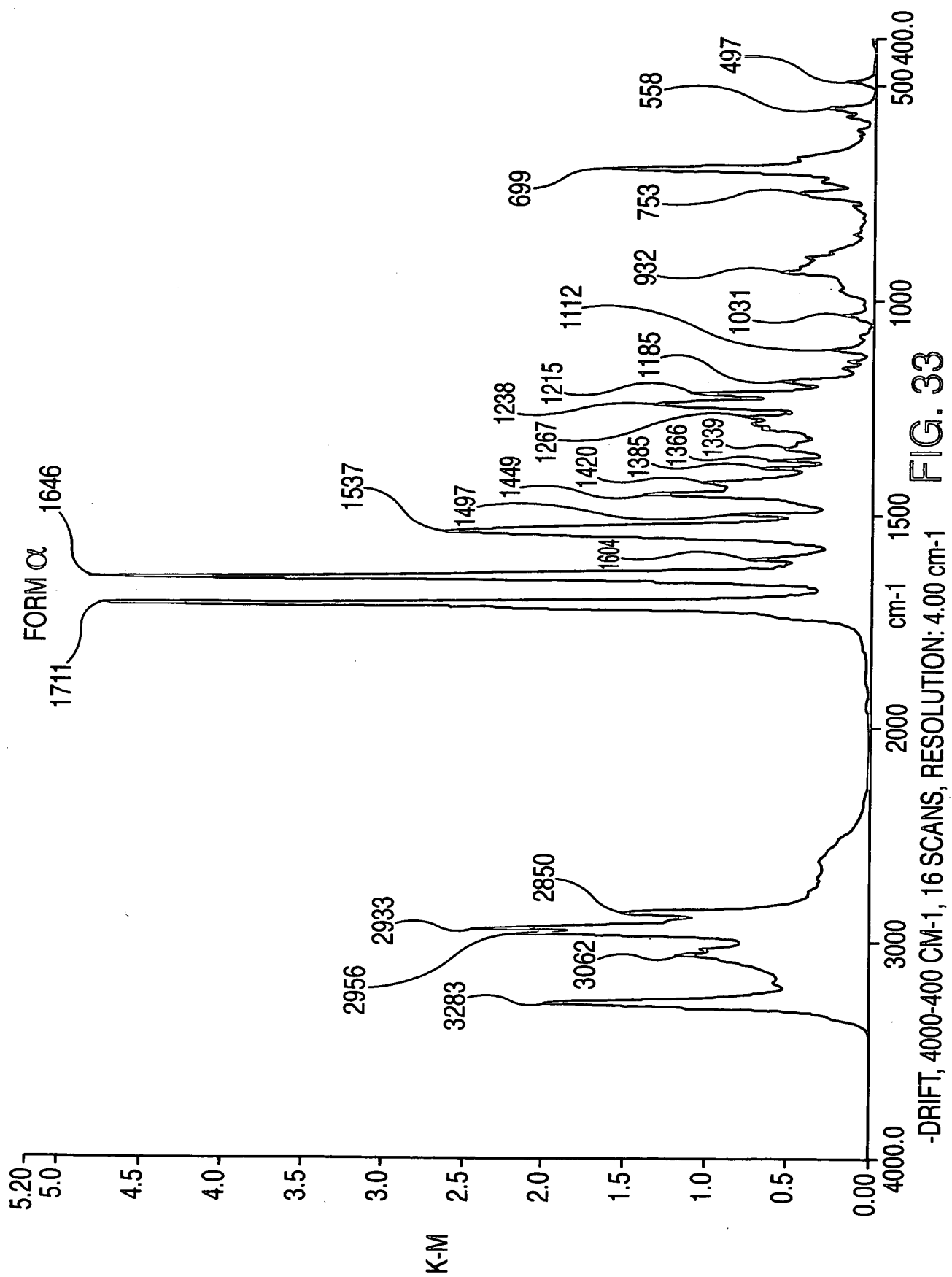
FIG. 28

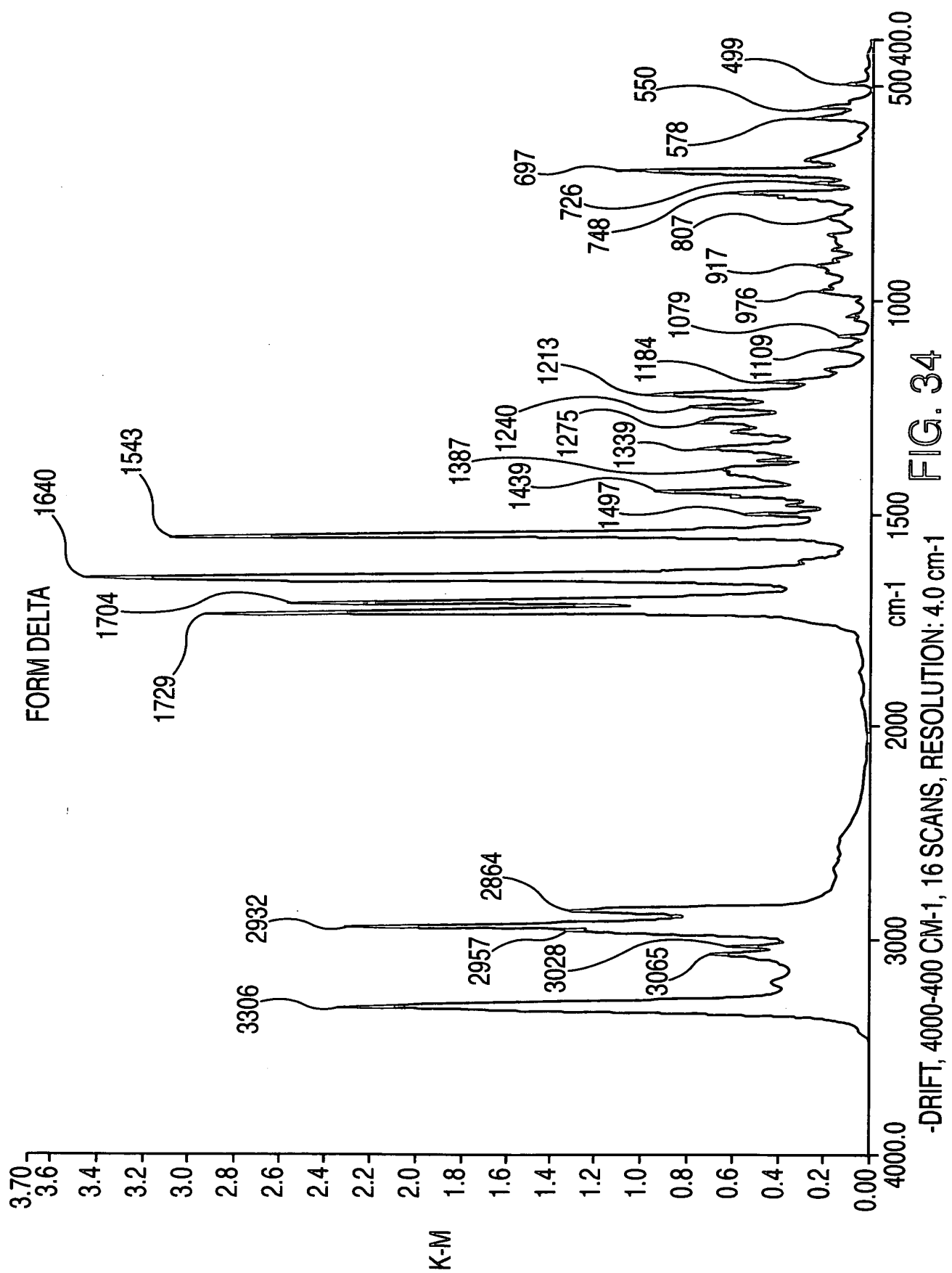












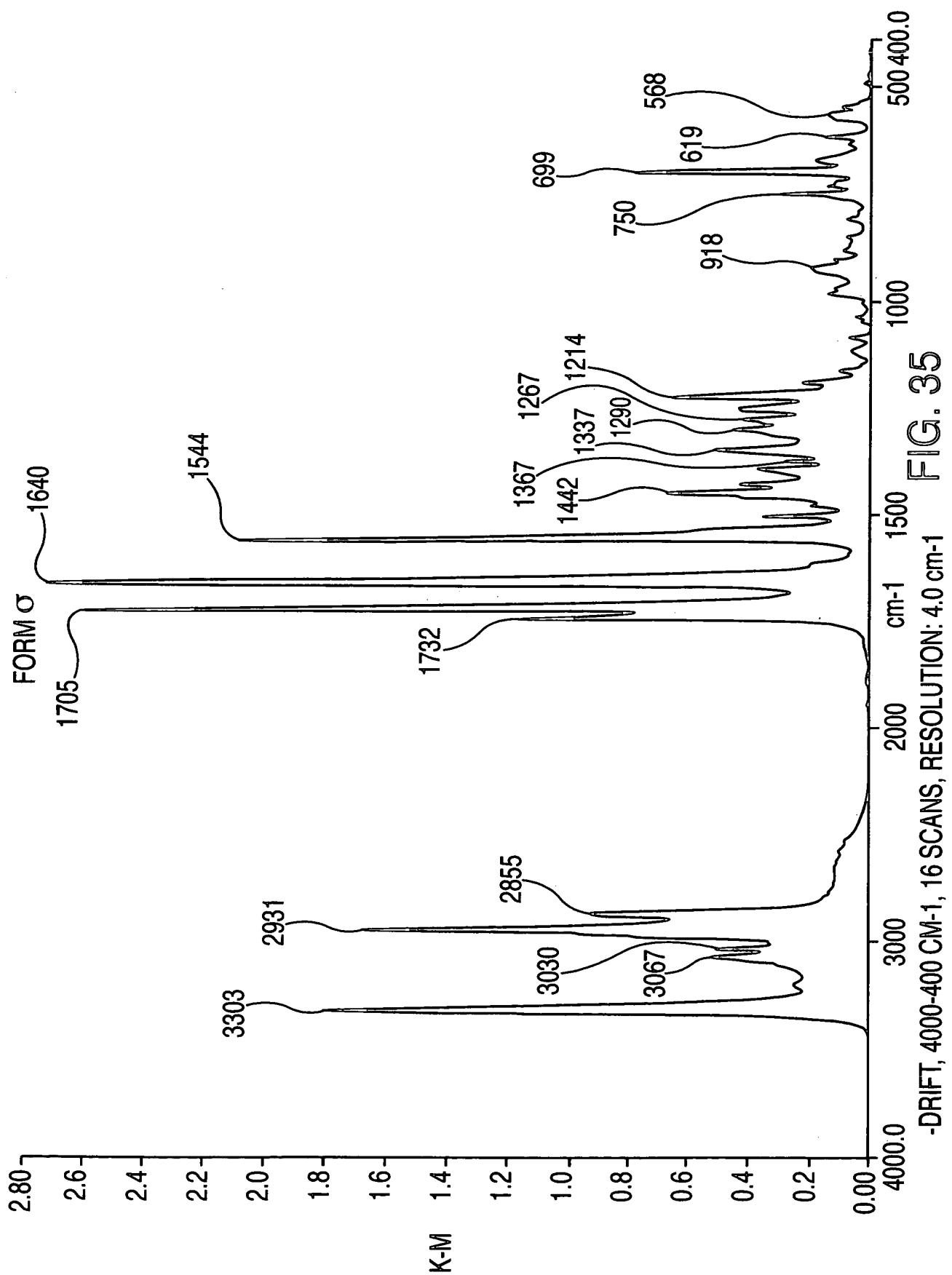
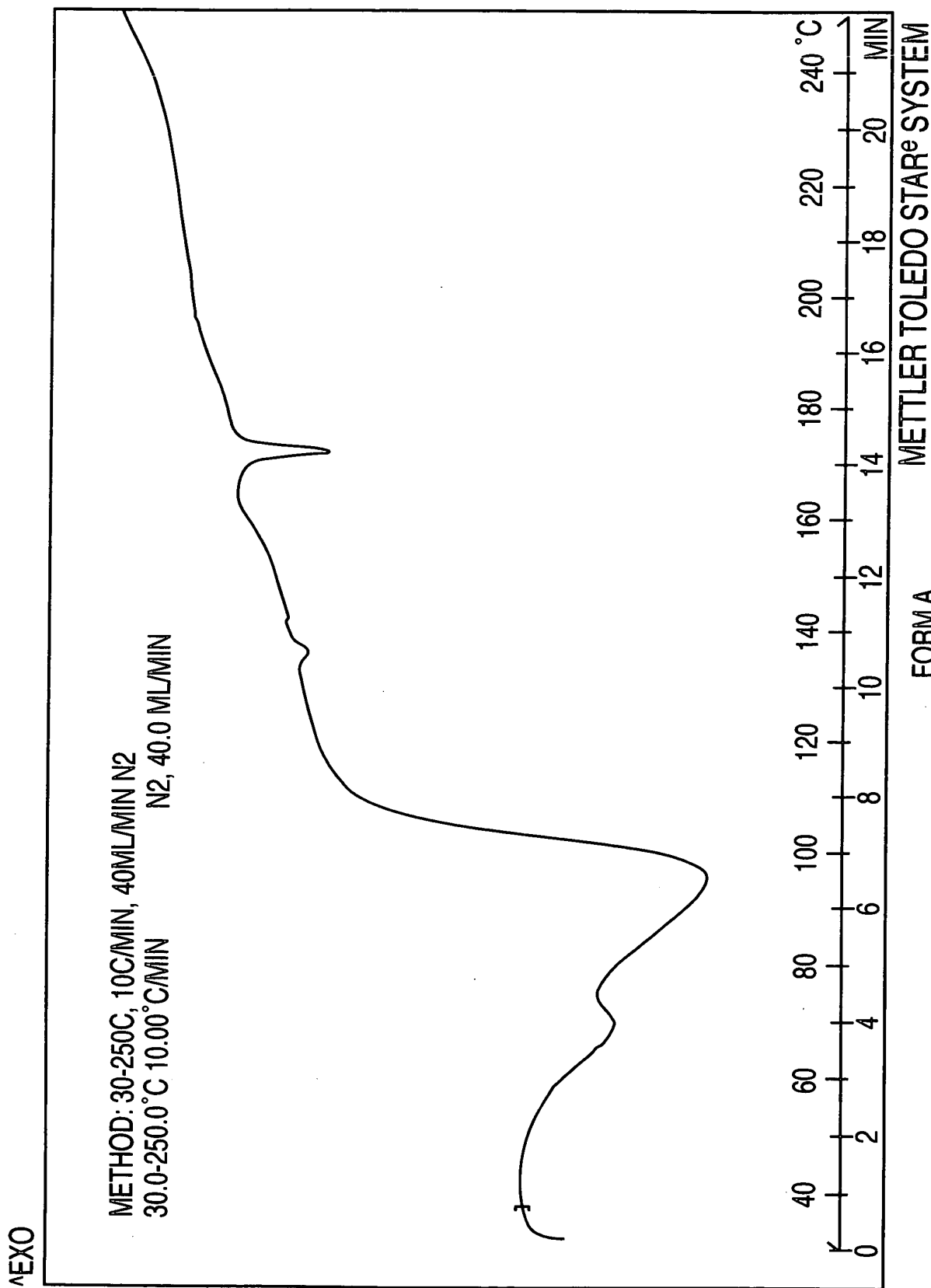
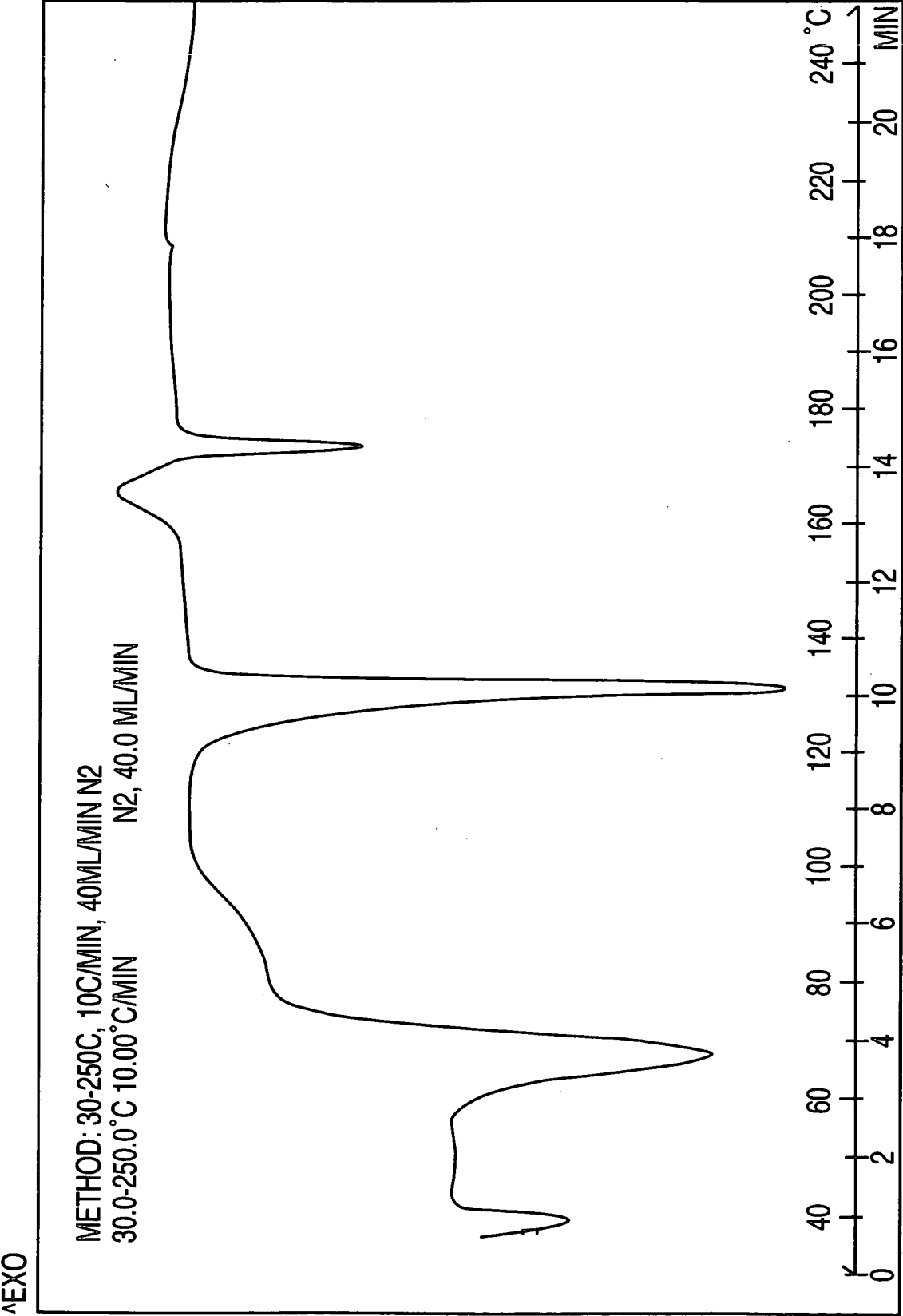


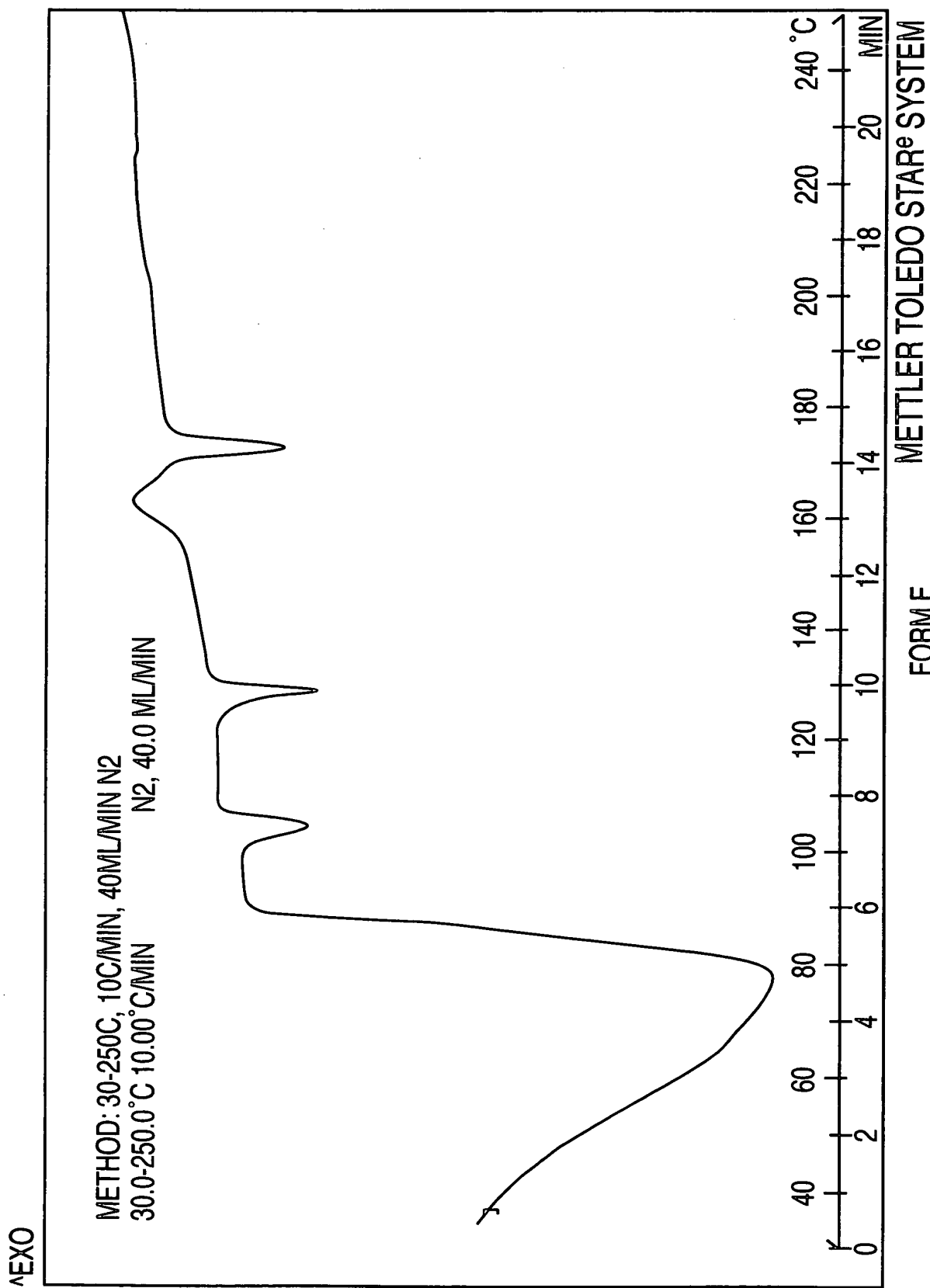
FIG. 35





METTLETTER TOLEDO STAR^e SYSTEM

FORM D
FIG. 37



FORM E
FIG. 38

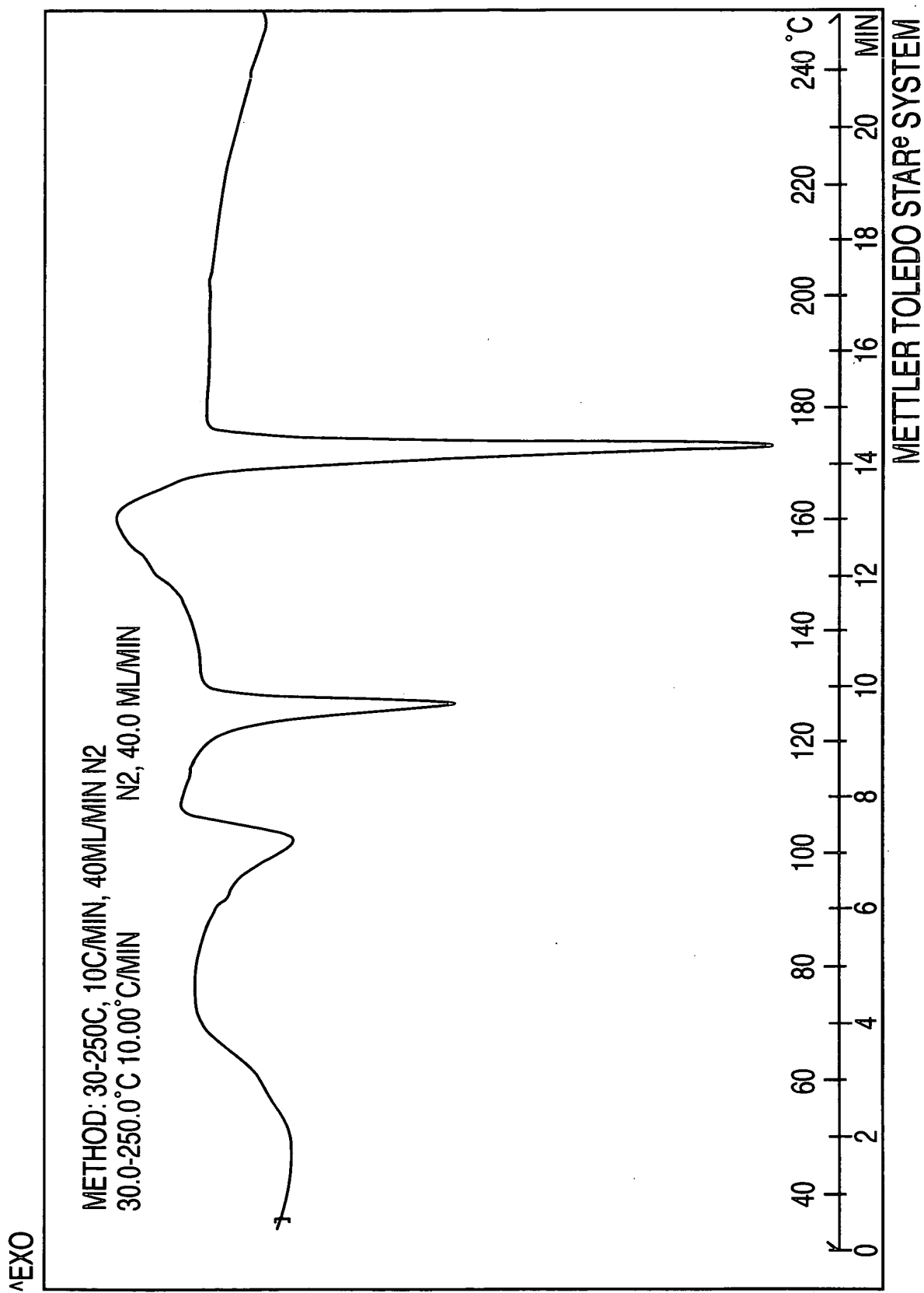


FIG. 39

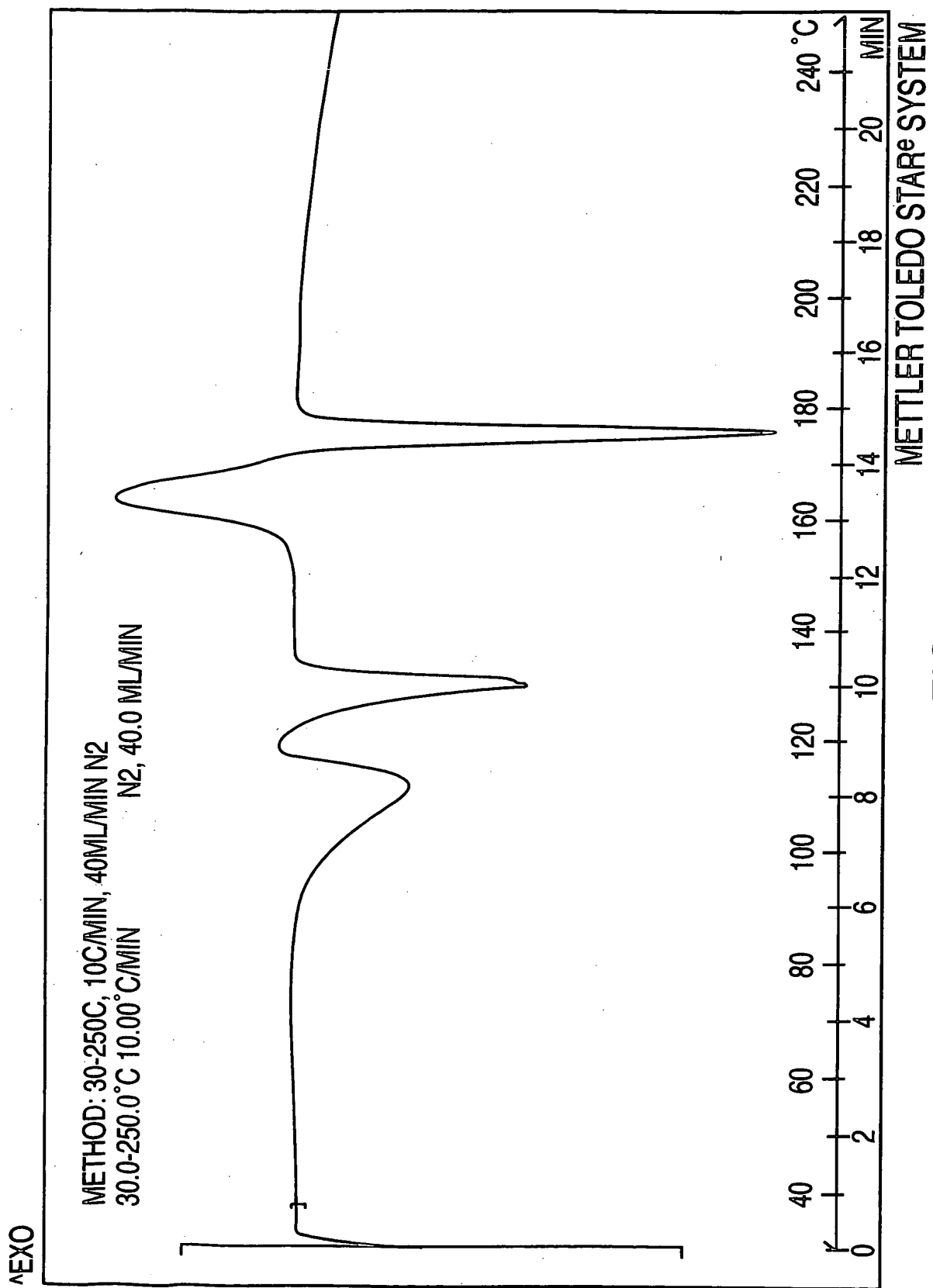
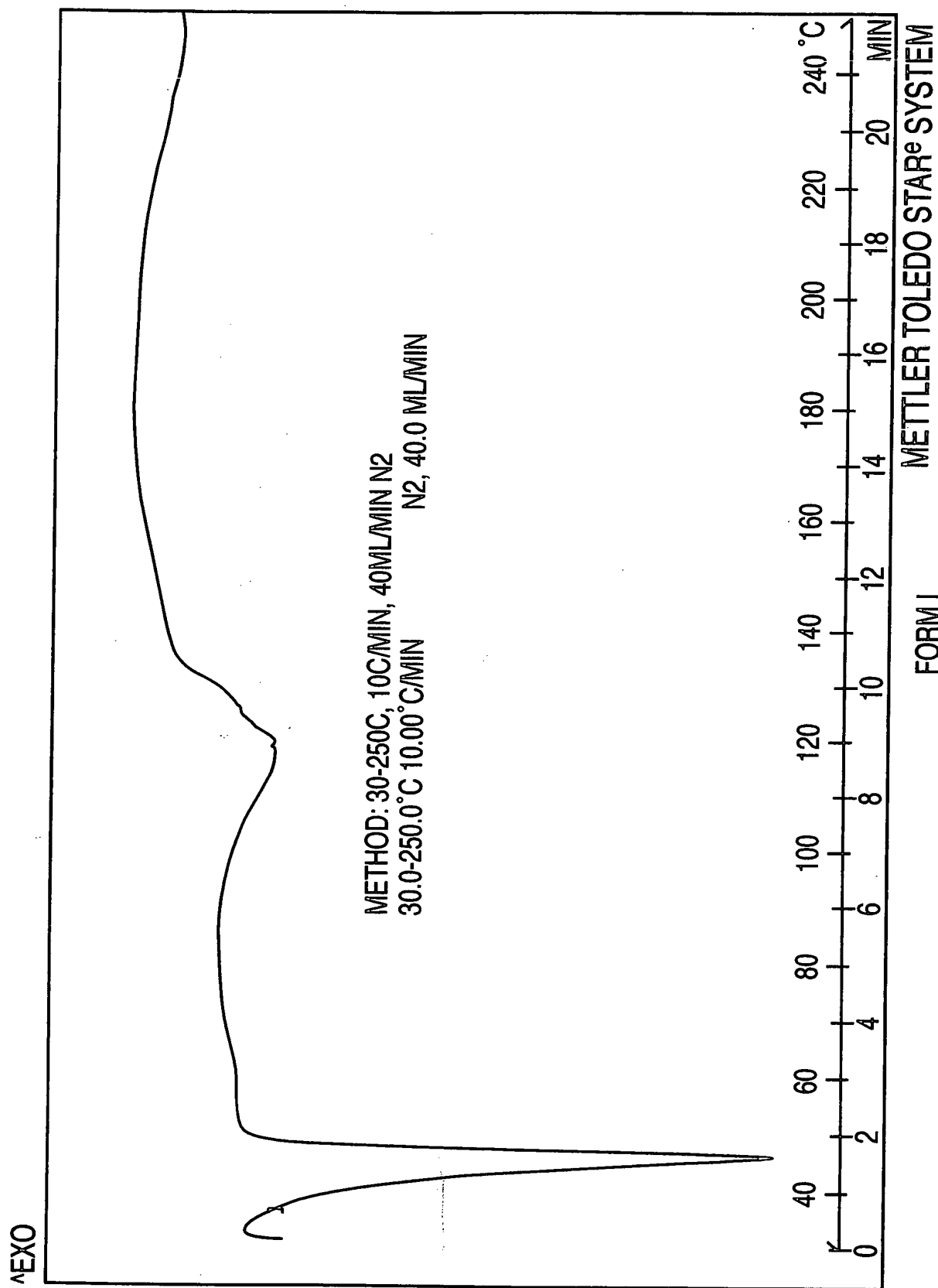


FIG. 40

FORM I
FIG. 41

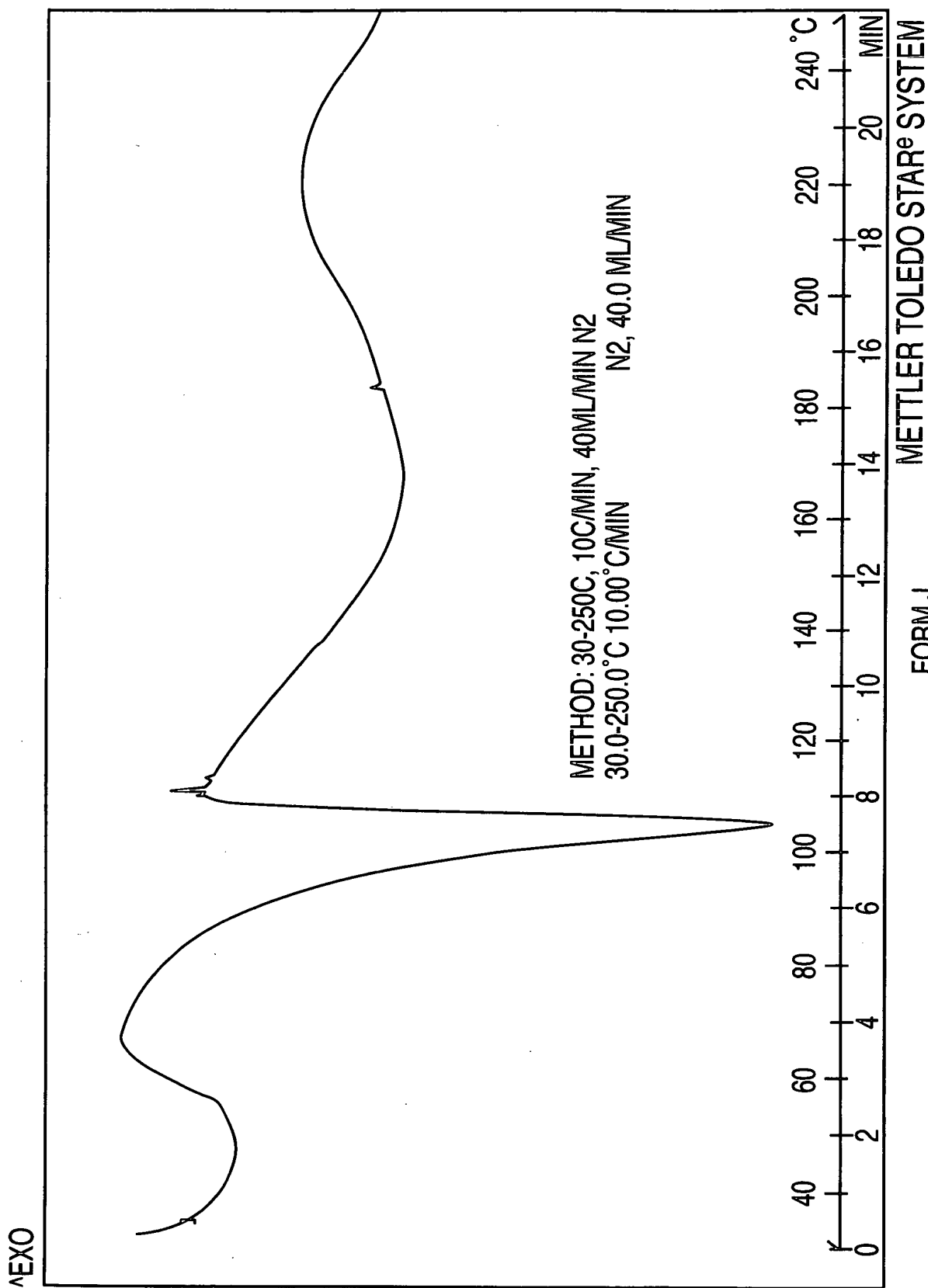


FIG. 42

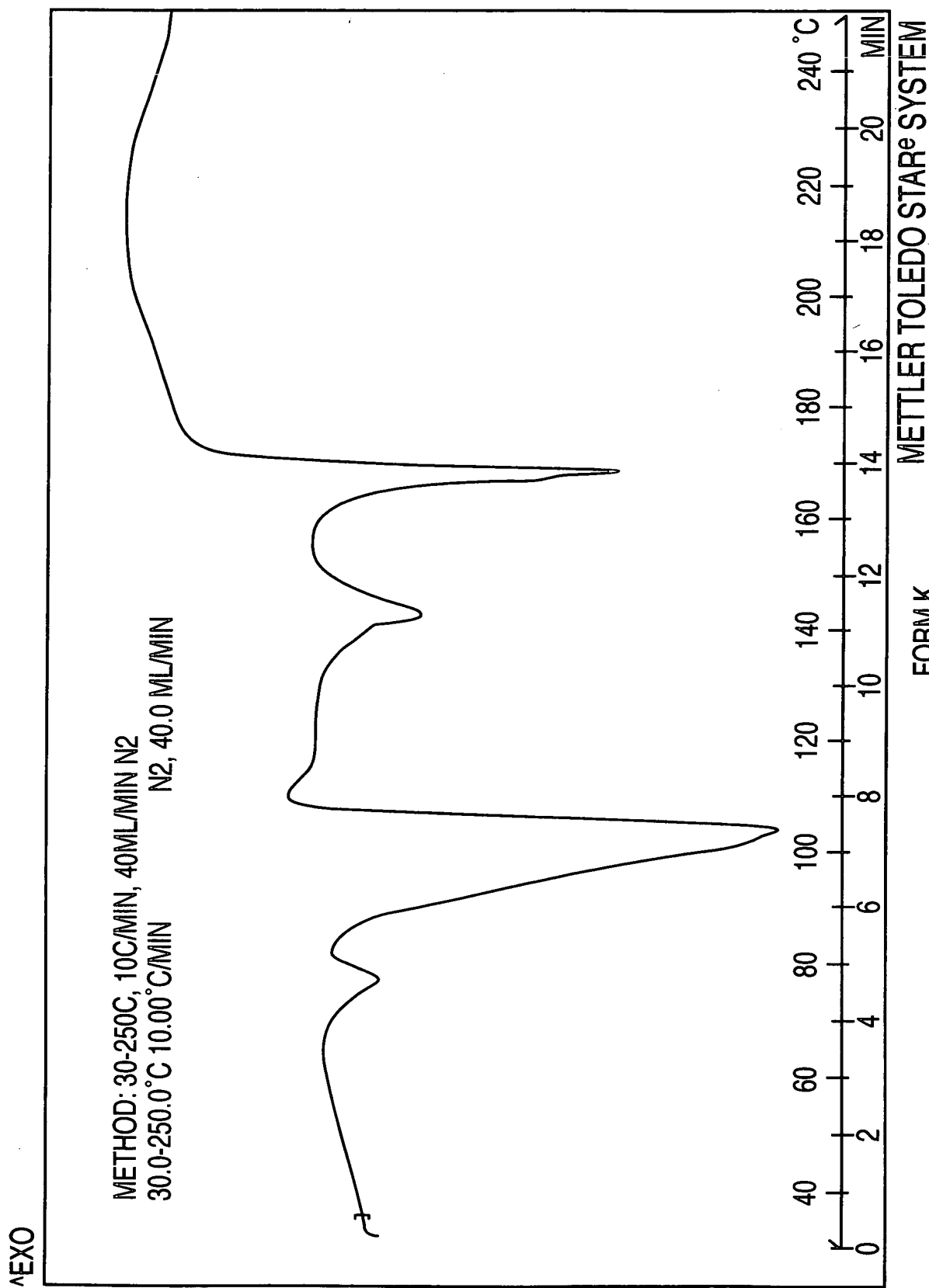


FIG. 43

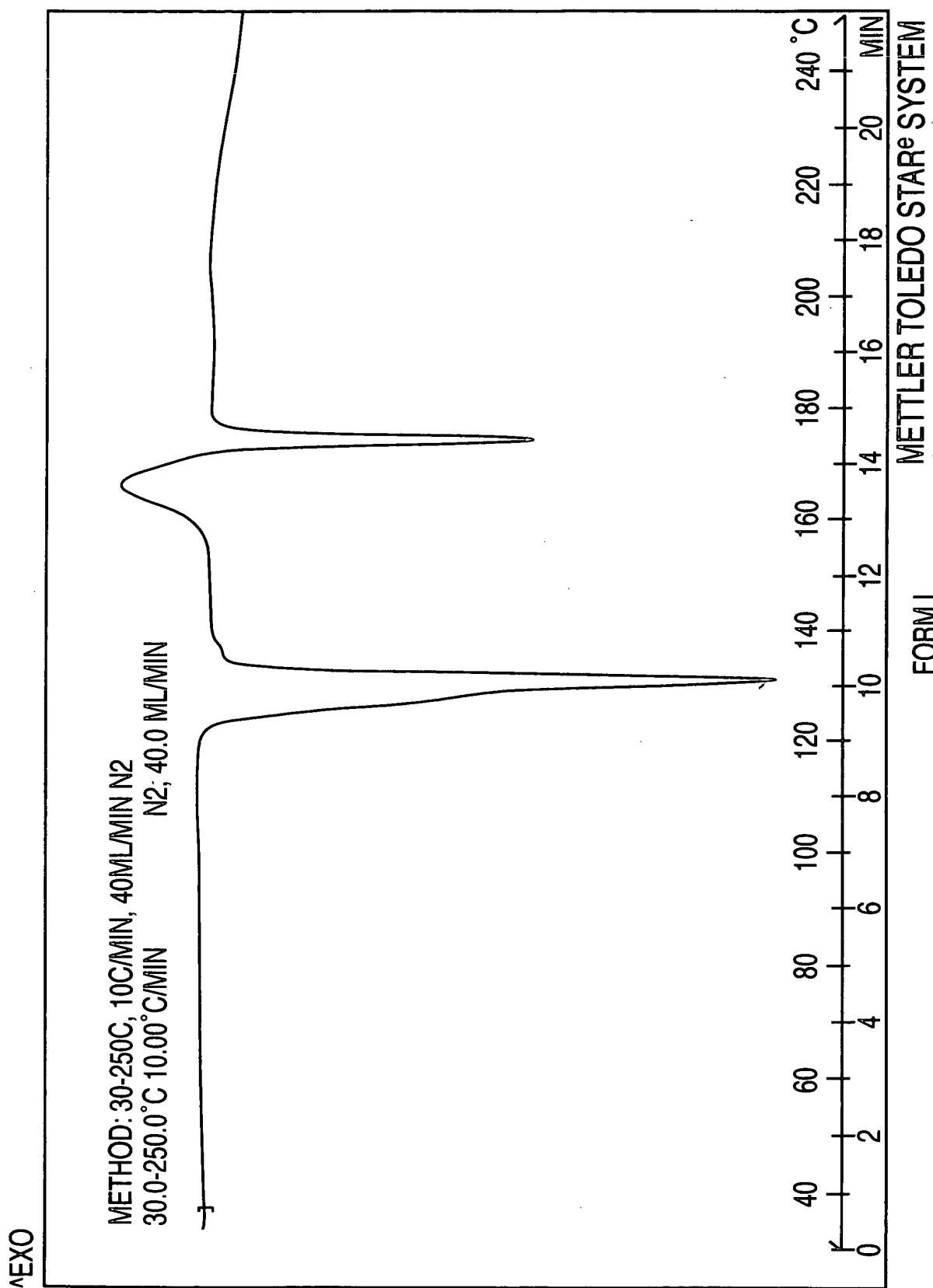
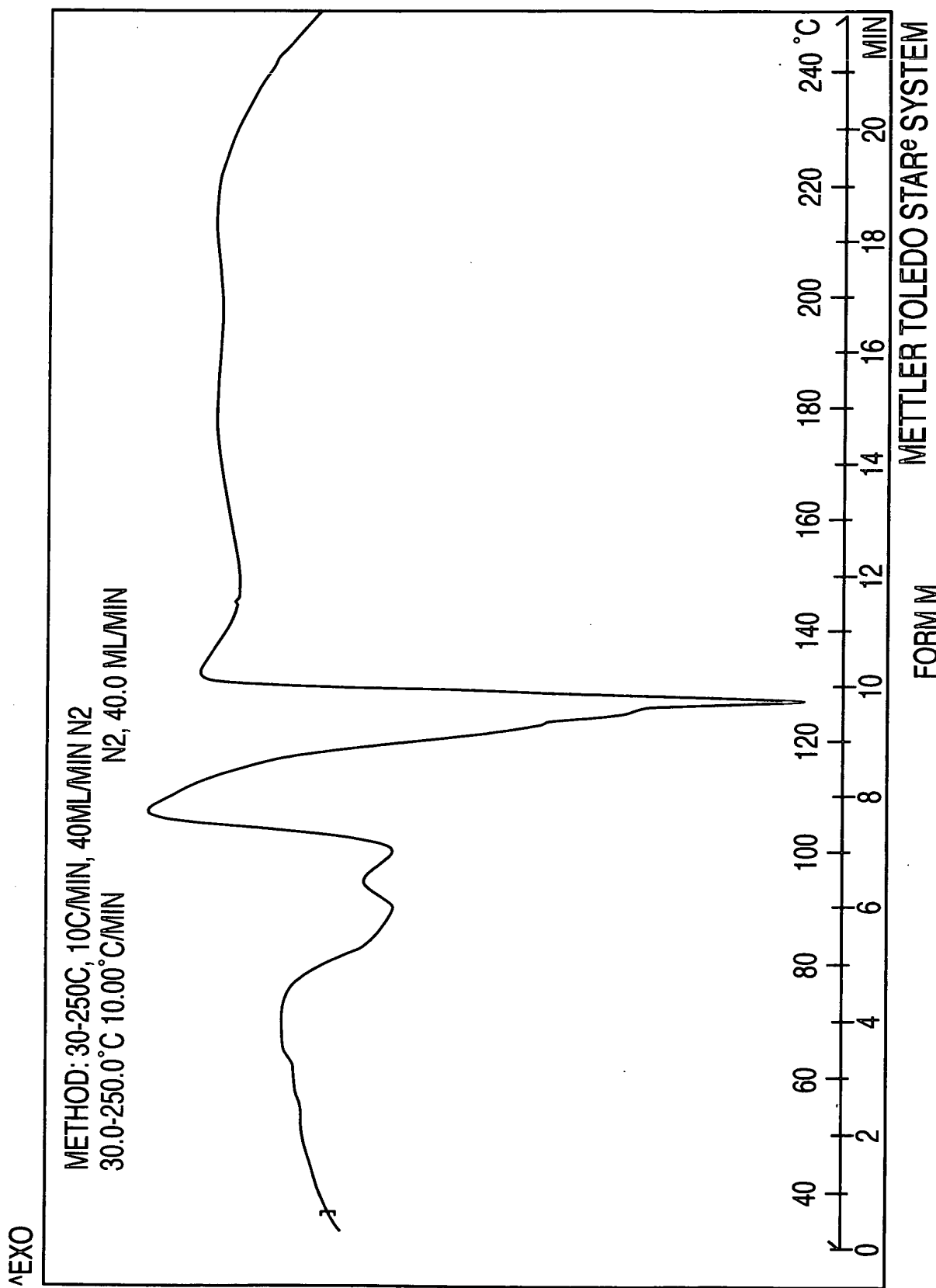
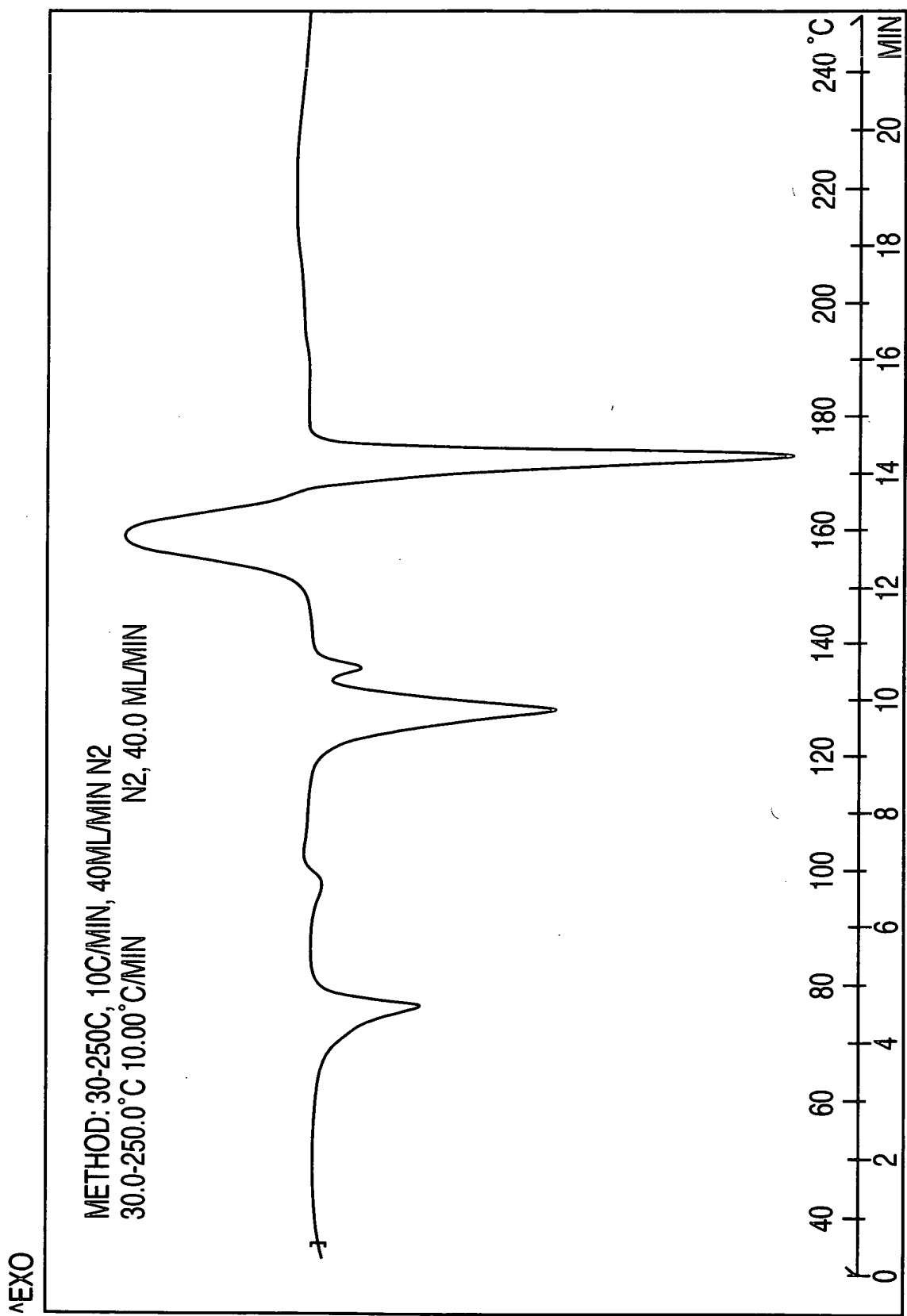


FIG. 44



METTLER TOLEDO STAR^e SYSTEMFORM N
FIG. 46

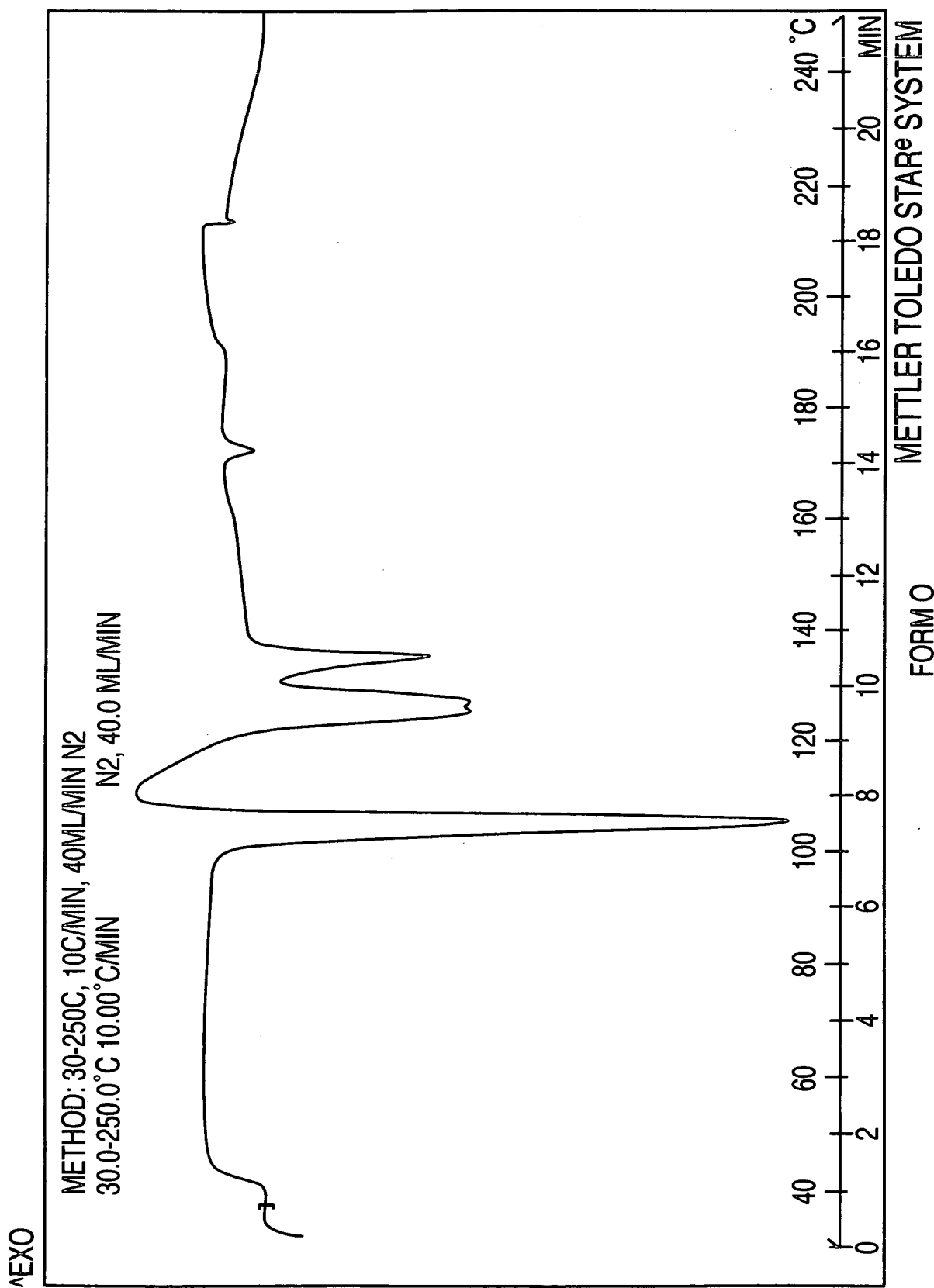
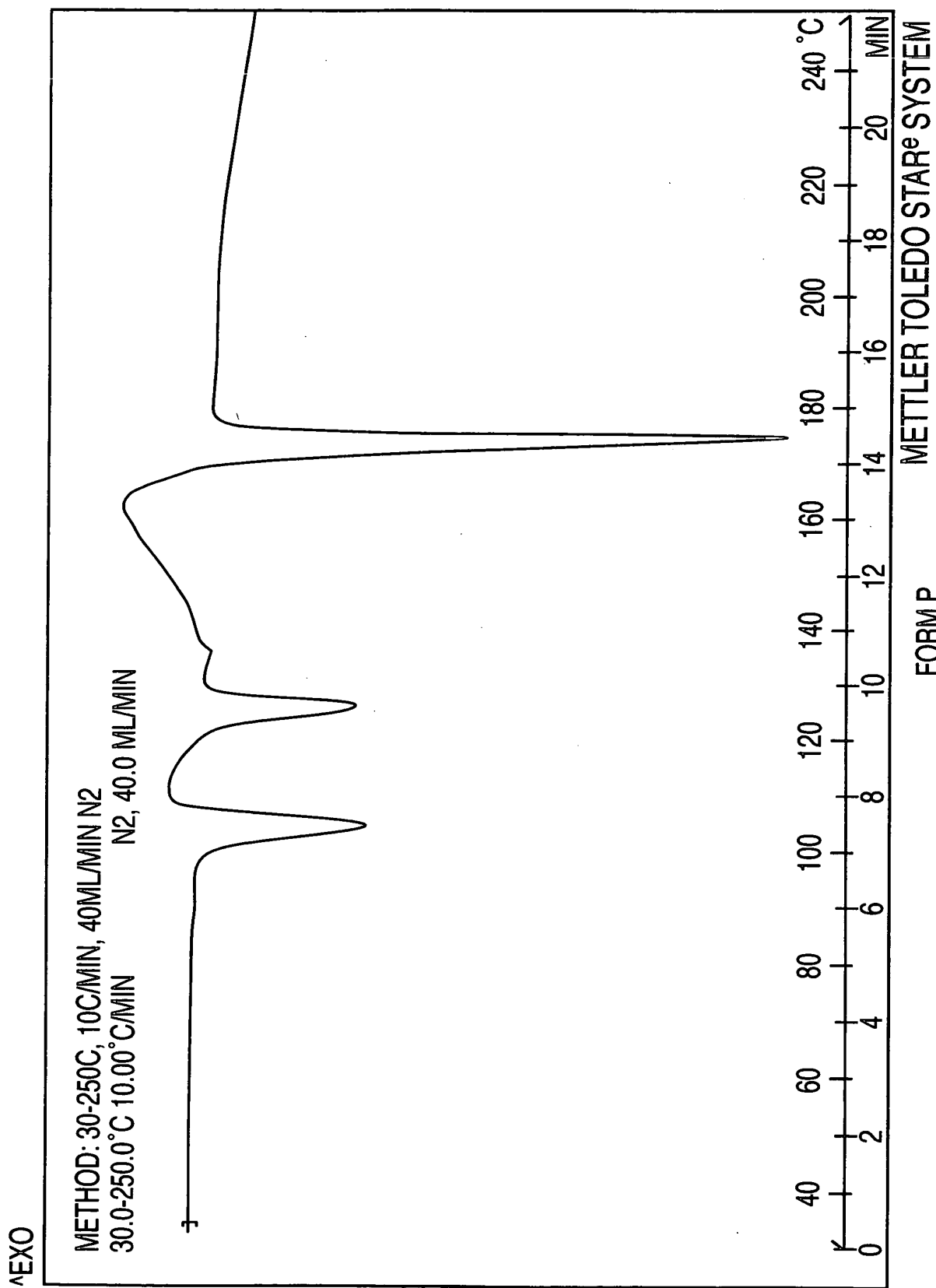
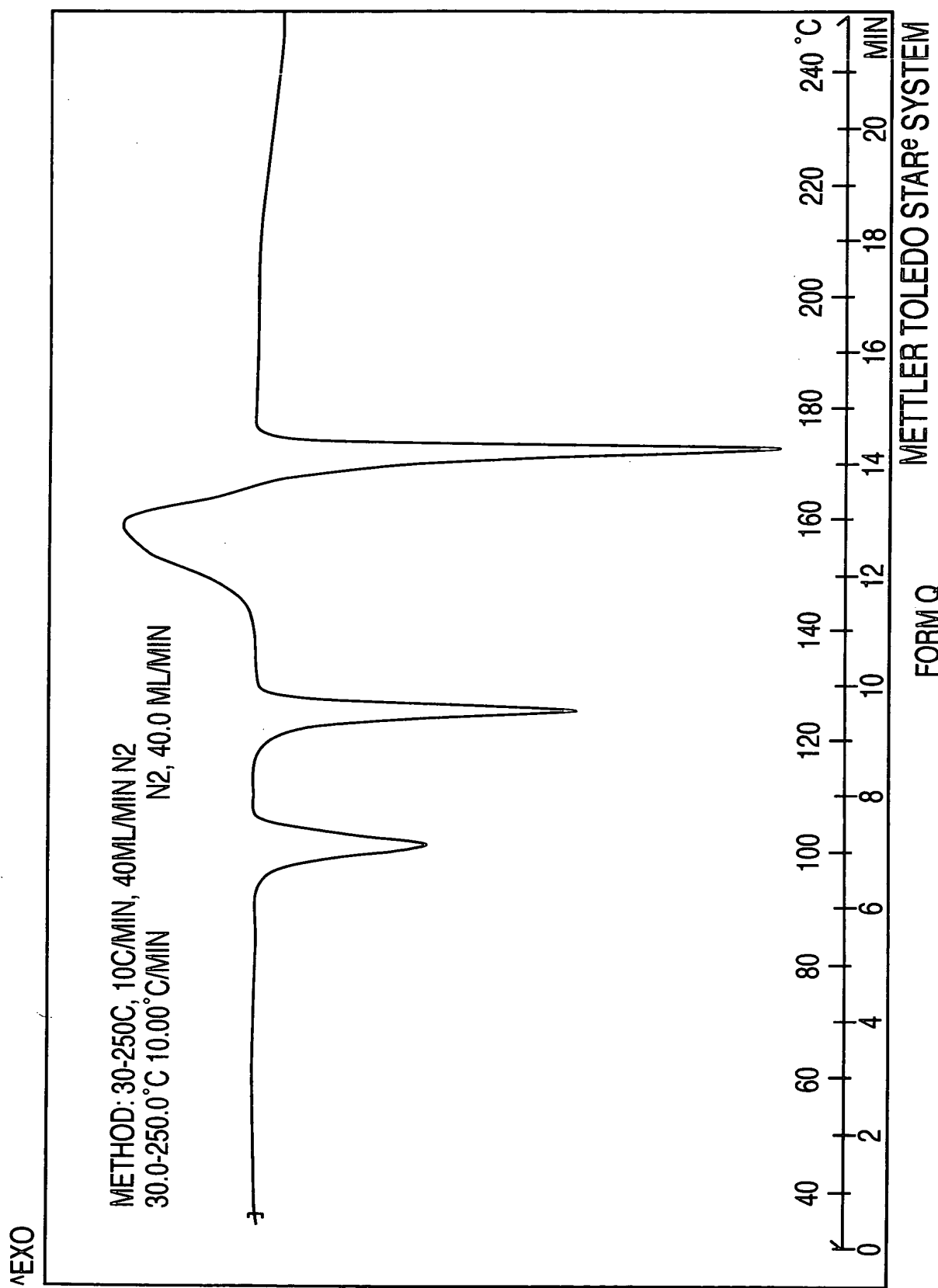


FIG. 47



FORM P
FIG. 48



FORM Q
FIG. 49

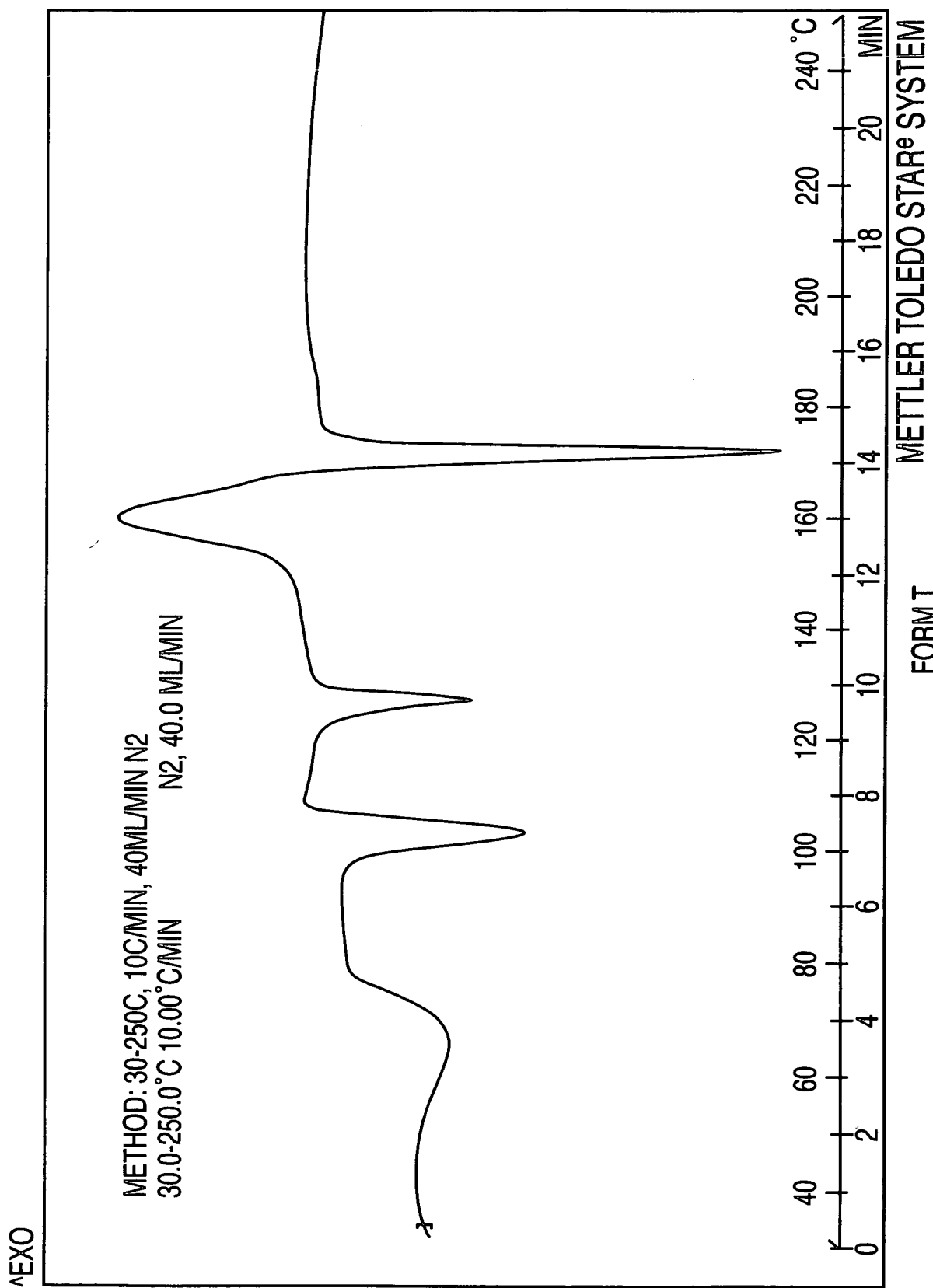
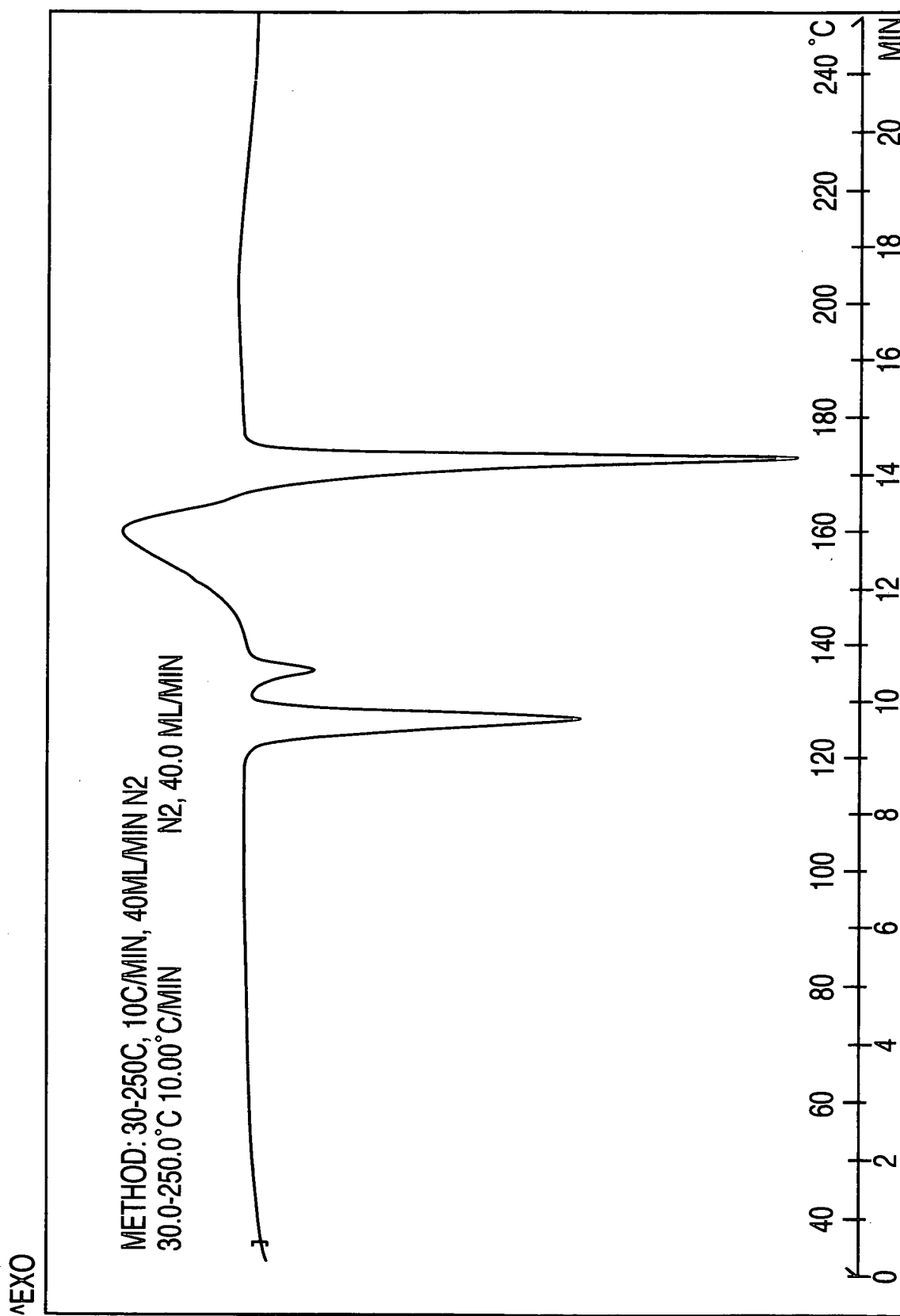


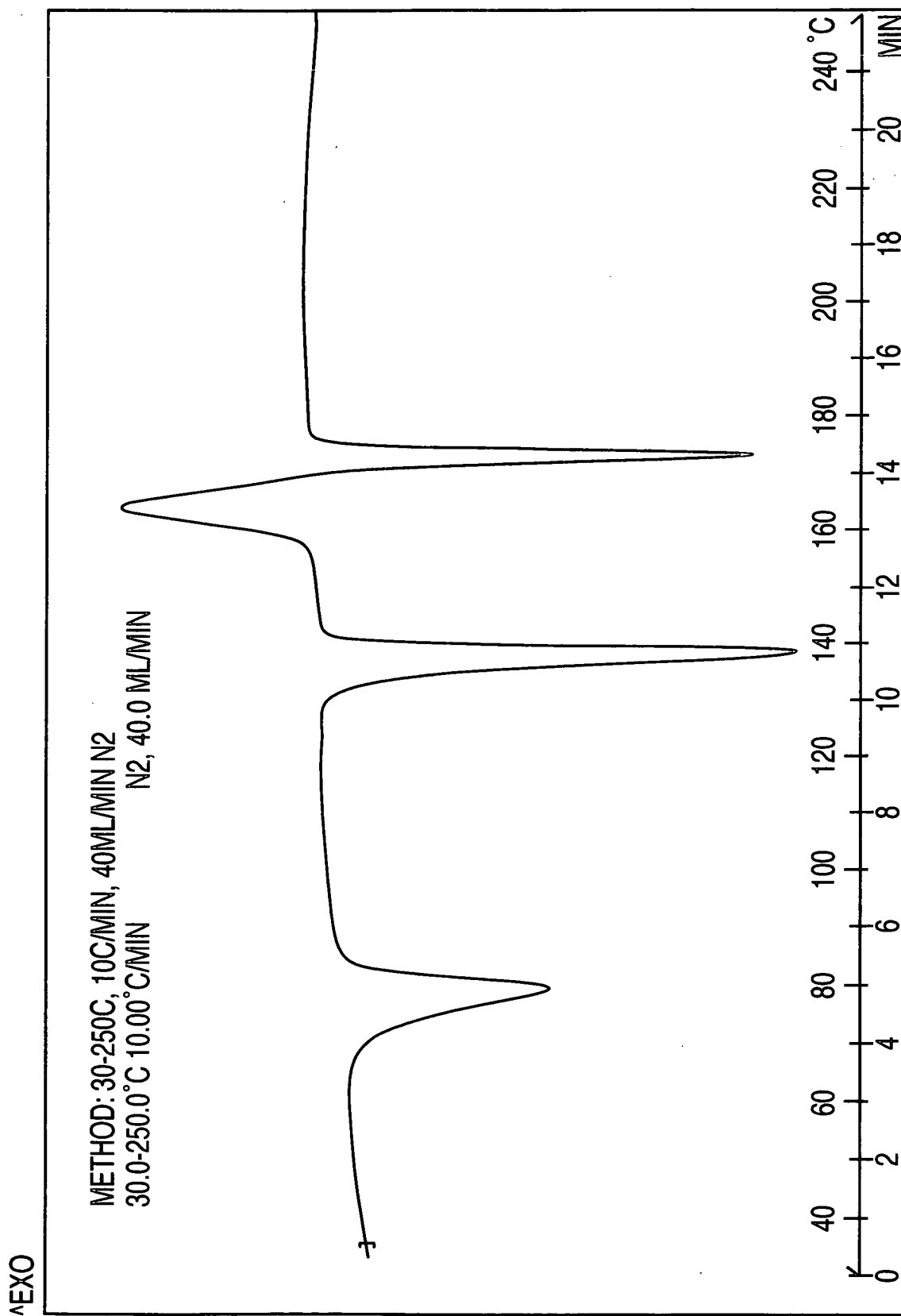
FIG. 50



METTLER TOLEDO STAR® SYSTEM

FORM U

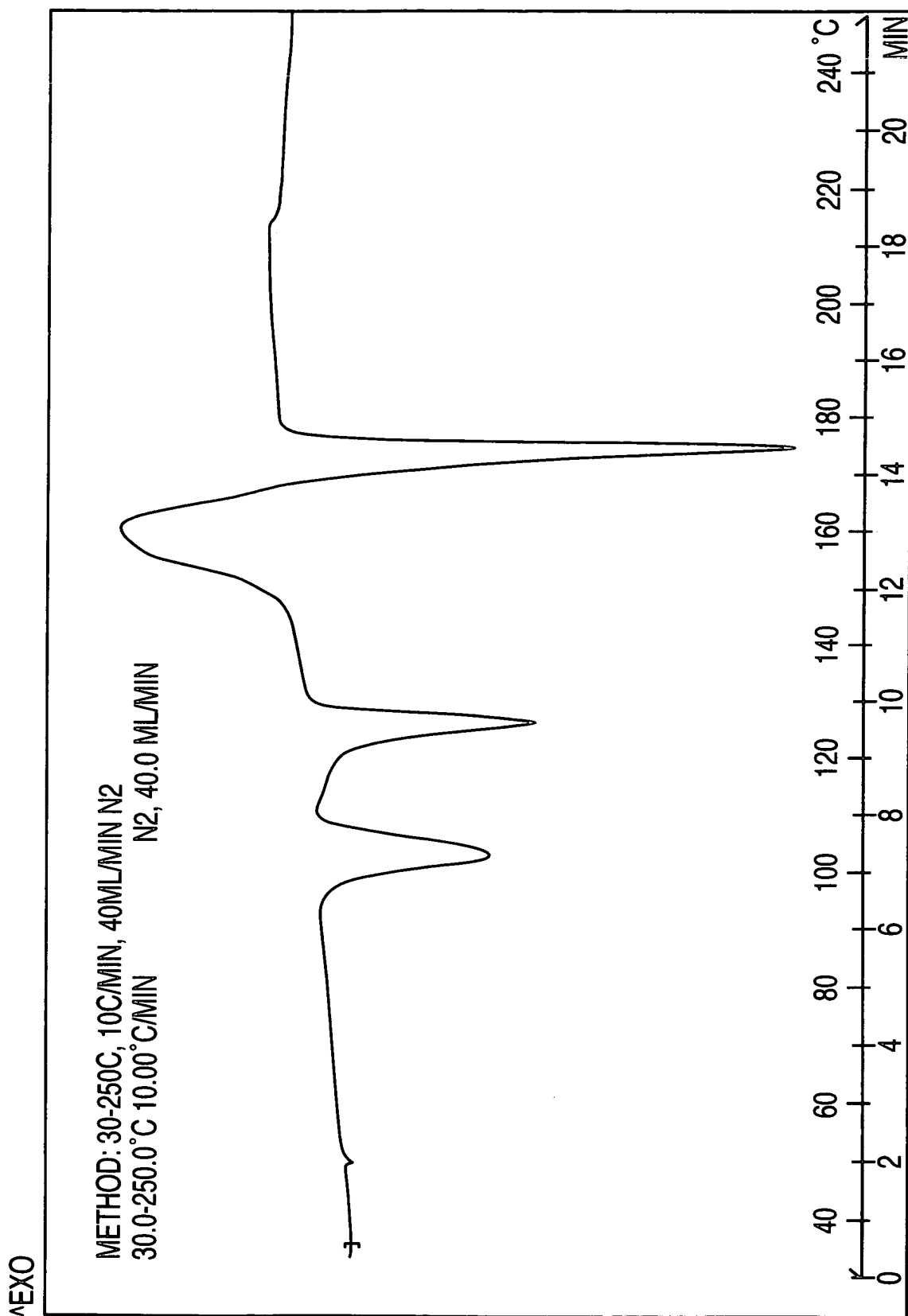
FIG. 51



METTLER TOLEDO STAR® SYSTEM

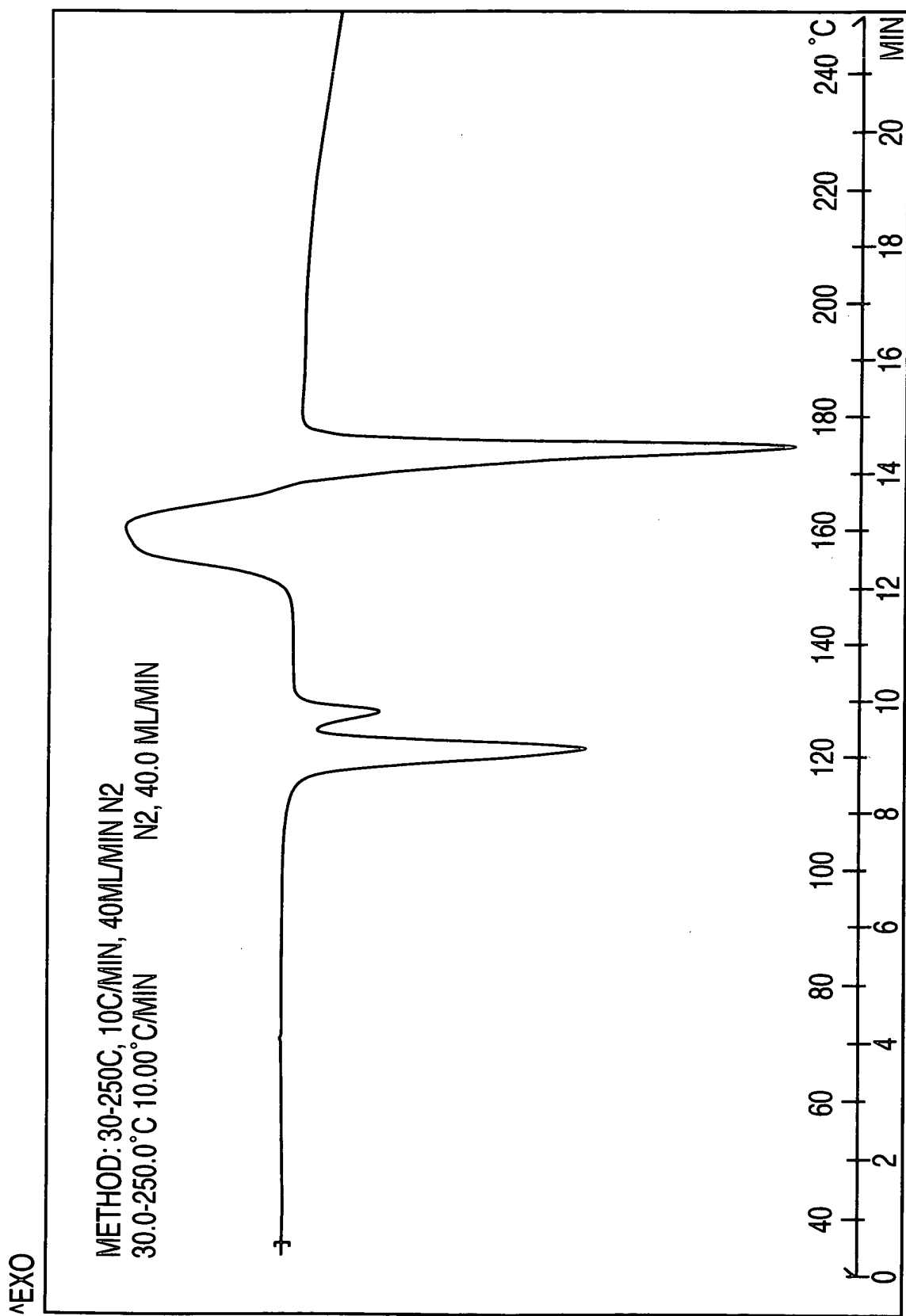
FORM V

FIG. 52

METTLER TOLEDO STAR^e SYSTEM

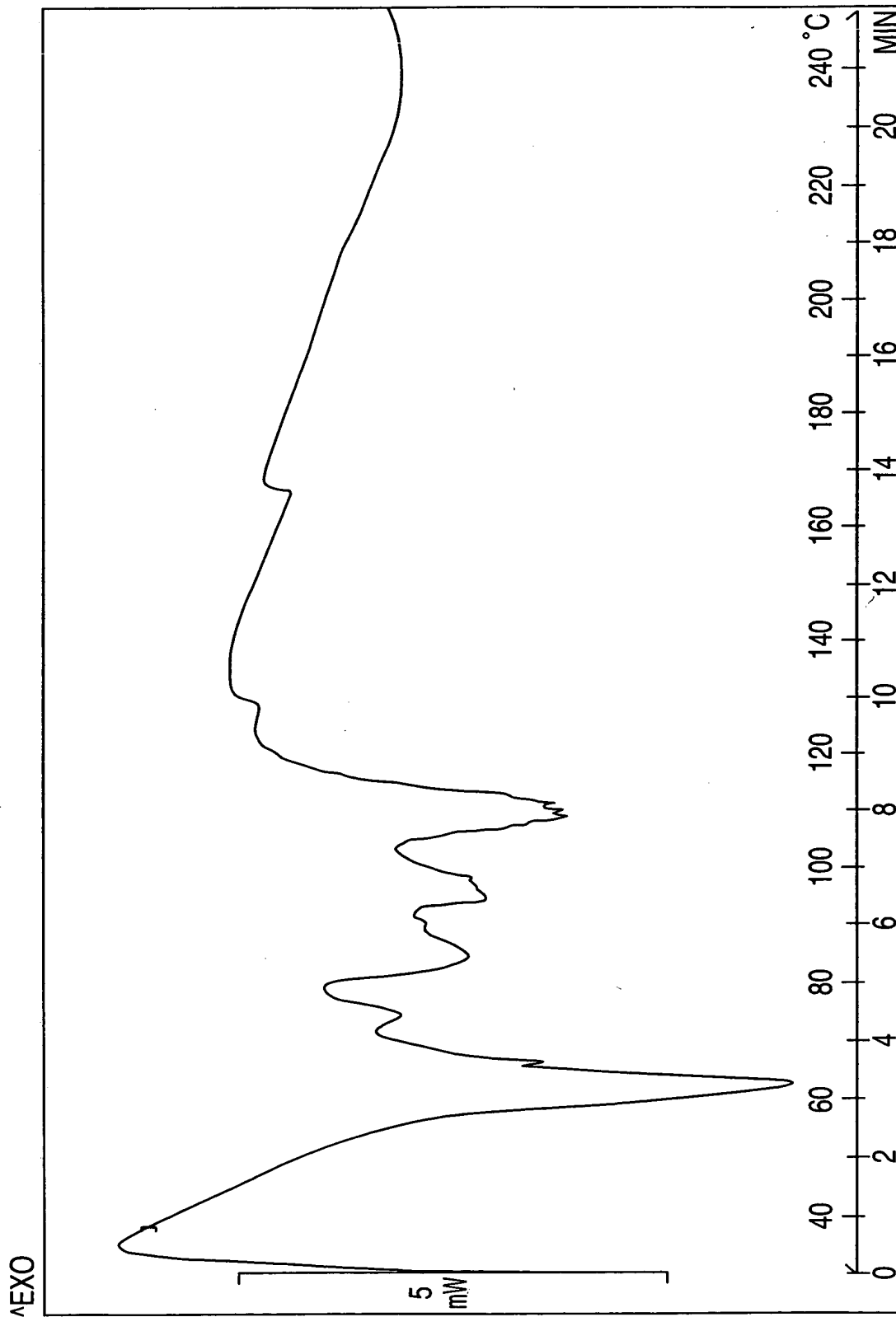
FORM Y (CHLOROFORM SOLVATE)

FIG. 53



METTLER TOLEDO STAR® SYSTEM

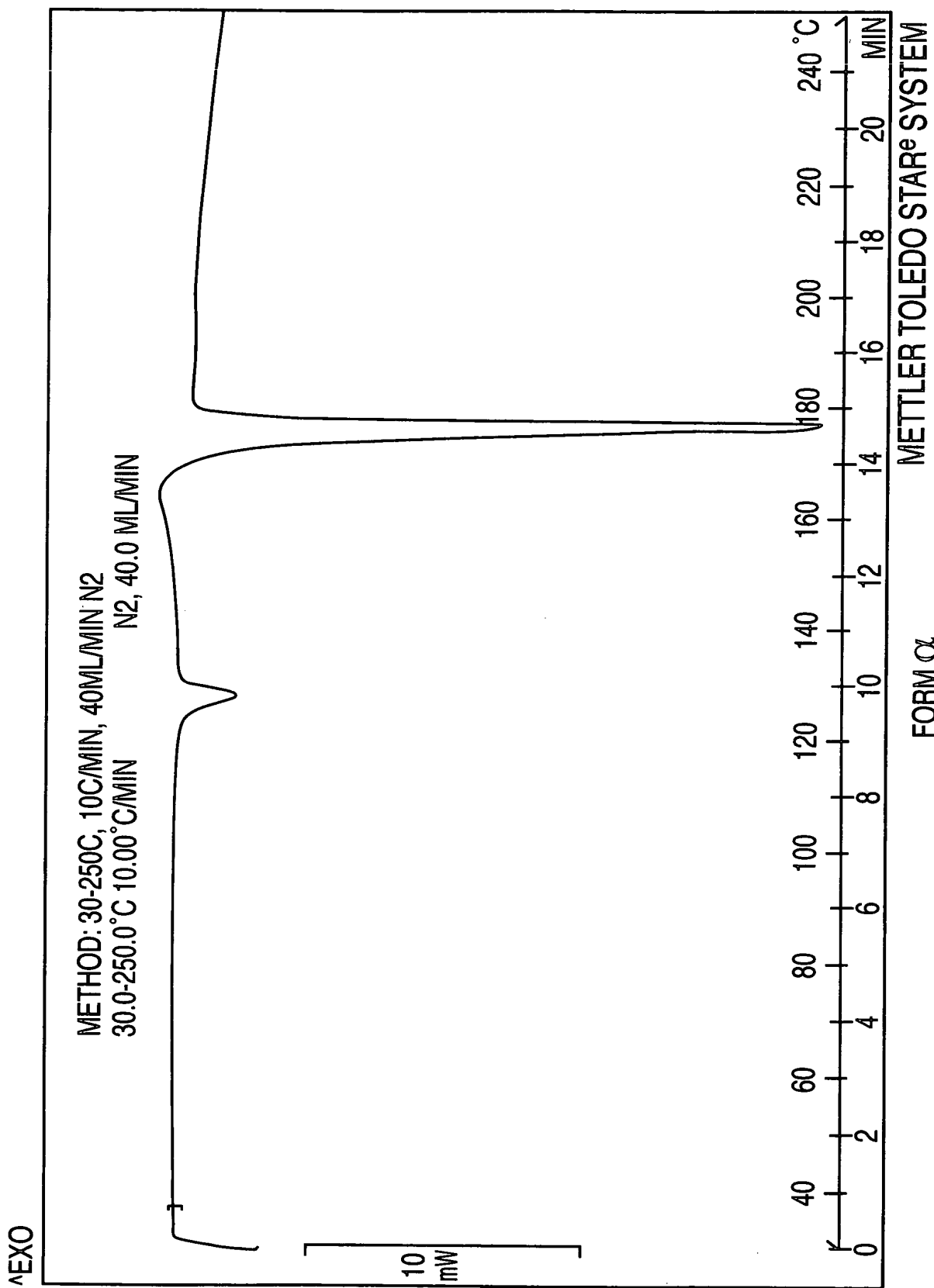
FIG. 54



METTLER TOLEDO STAR^e SYSTEM

NATEGLINIDE FORM Z

FIG. 55



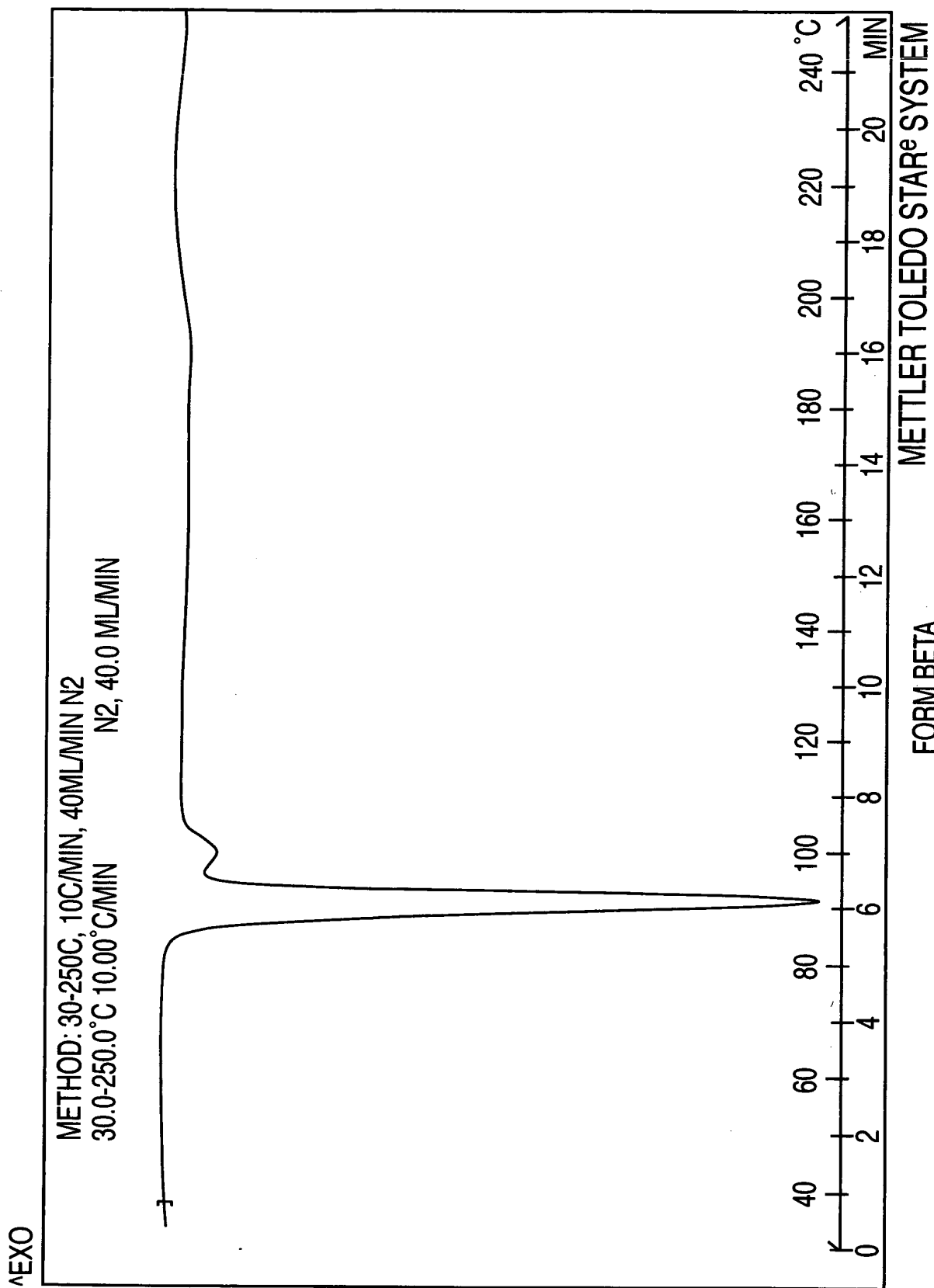
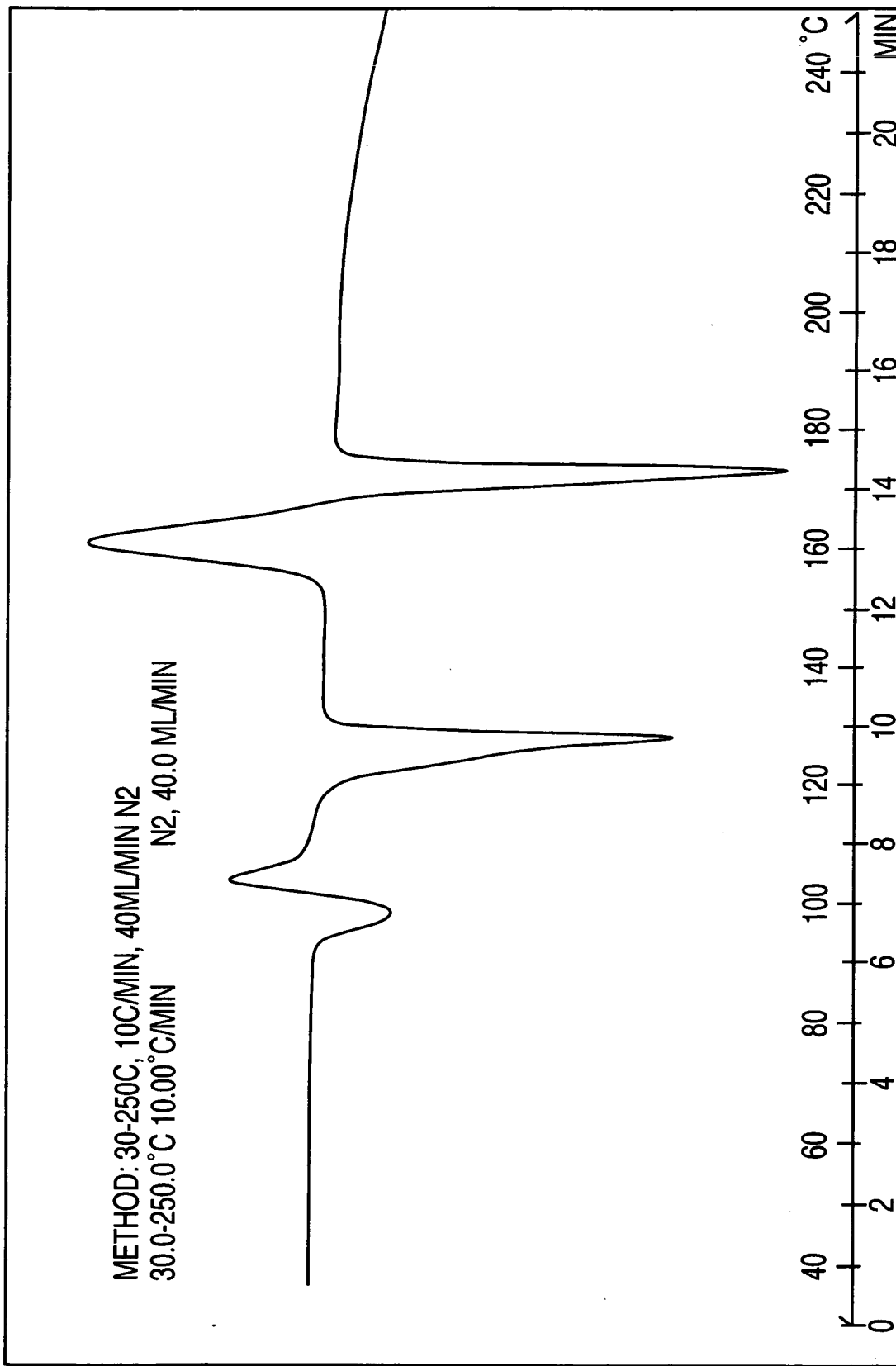


FIG. 57

^EXO



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METTLER TOLEDO STAR^e SYSTEM

FORM DELTA

FIG. 58

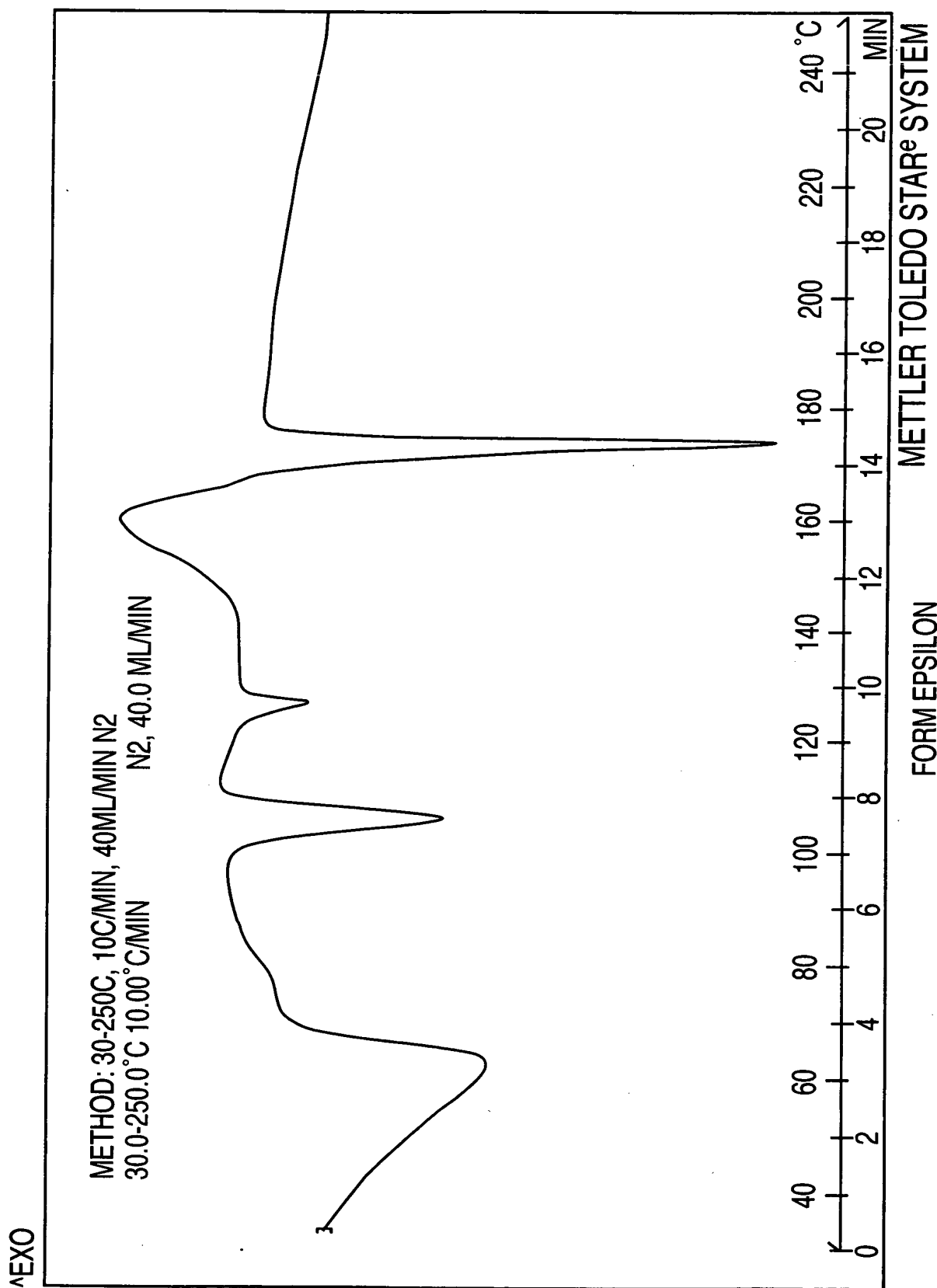
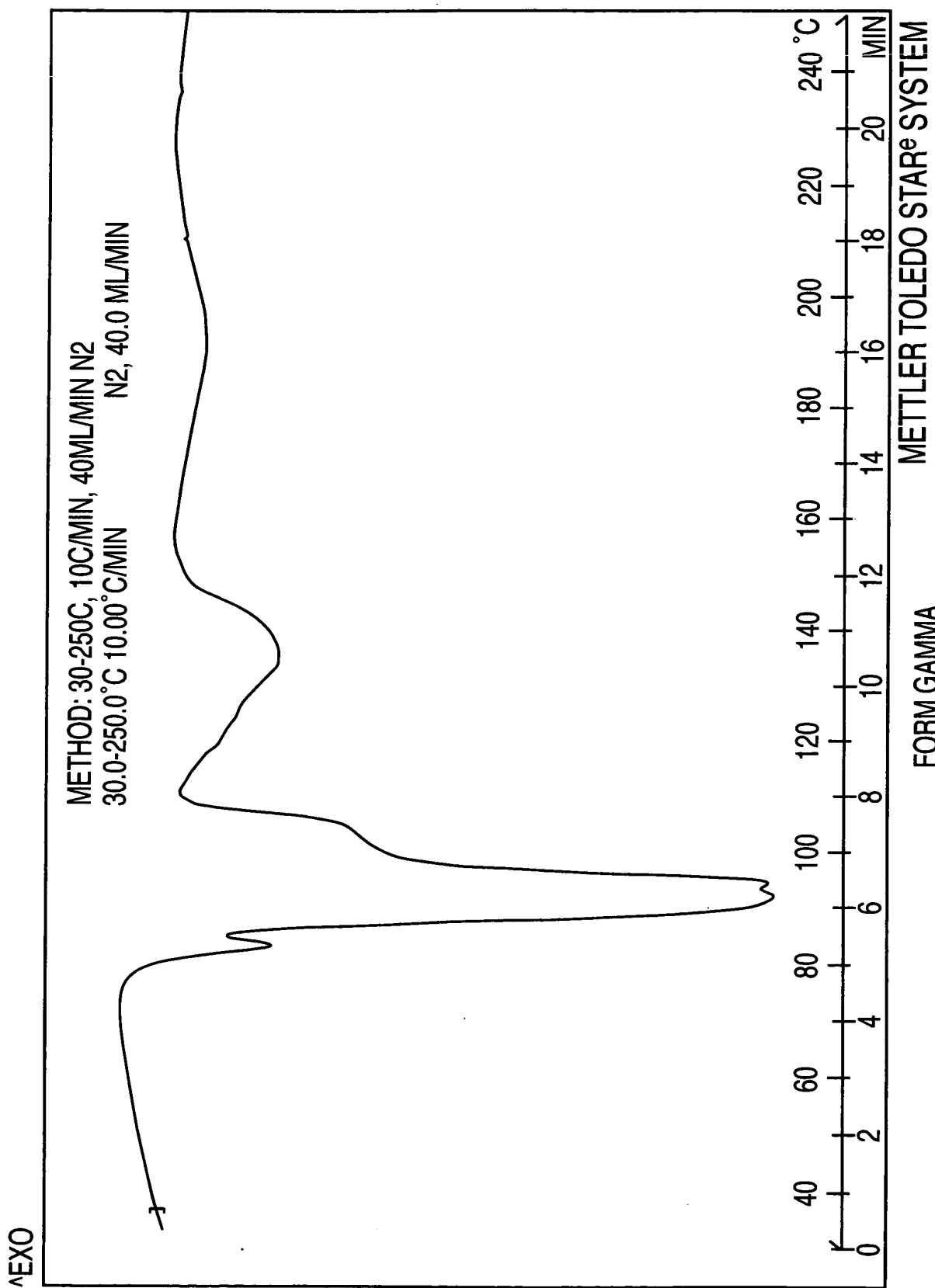


FIG. 59



FORM GAMMA

FIG. 60

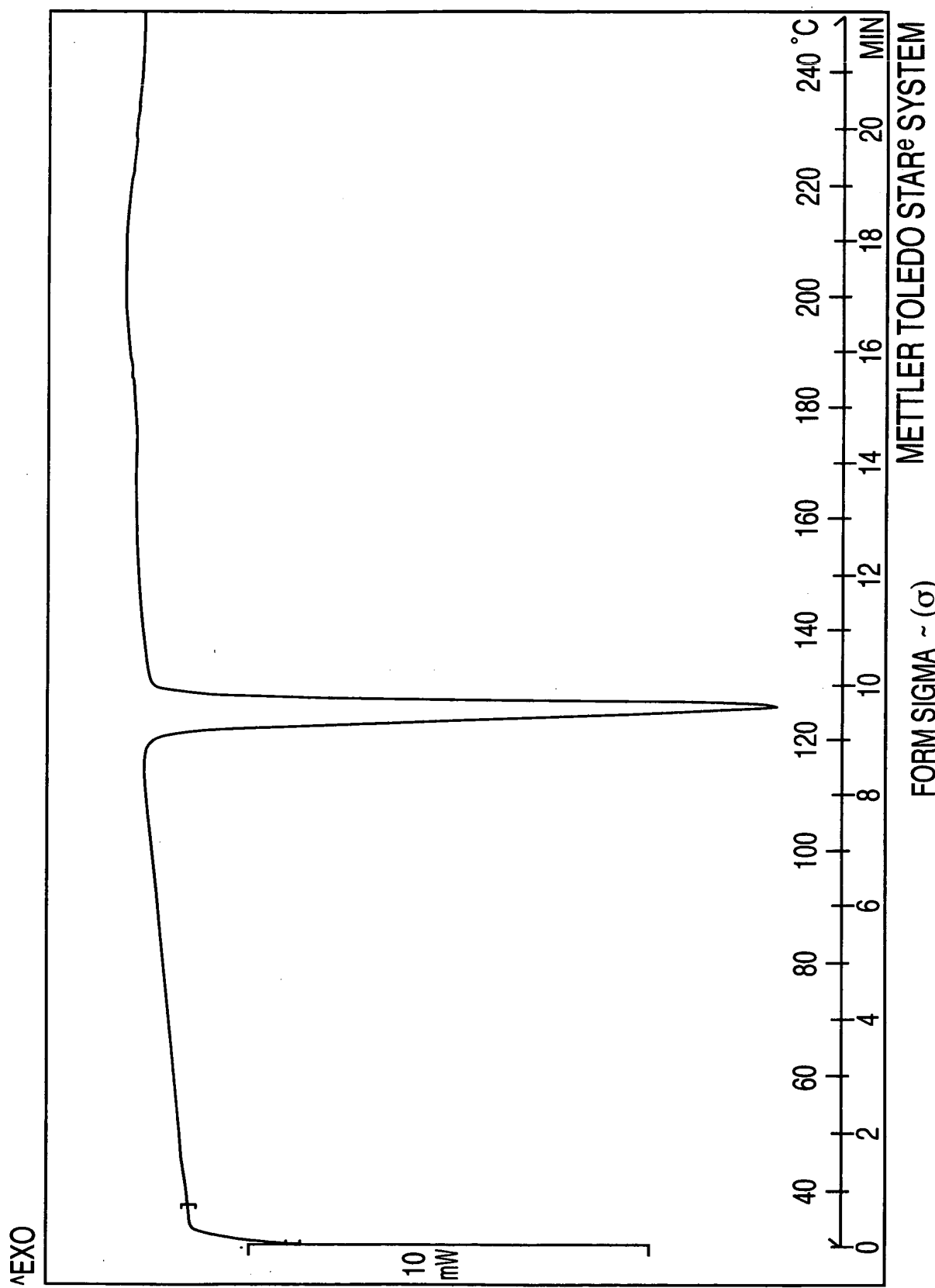


FIG. 61

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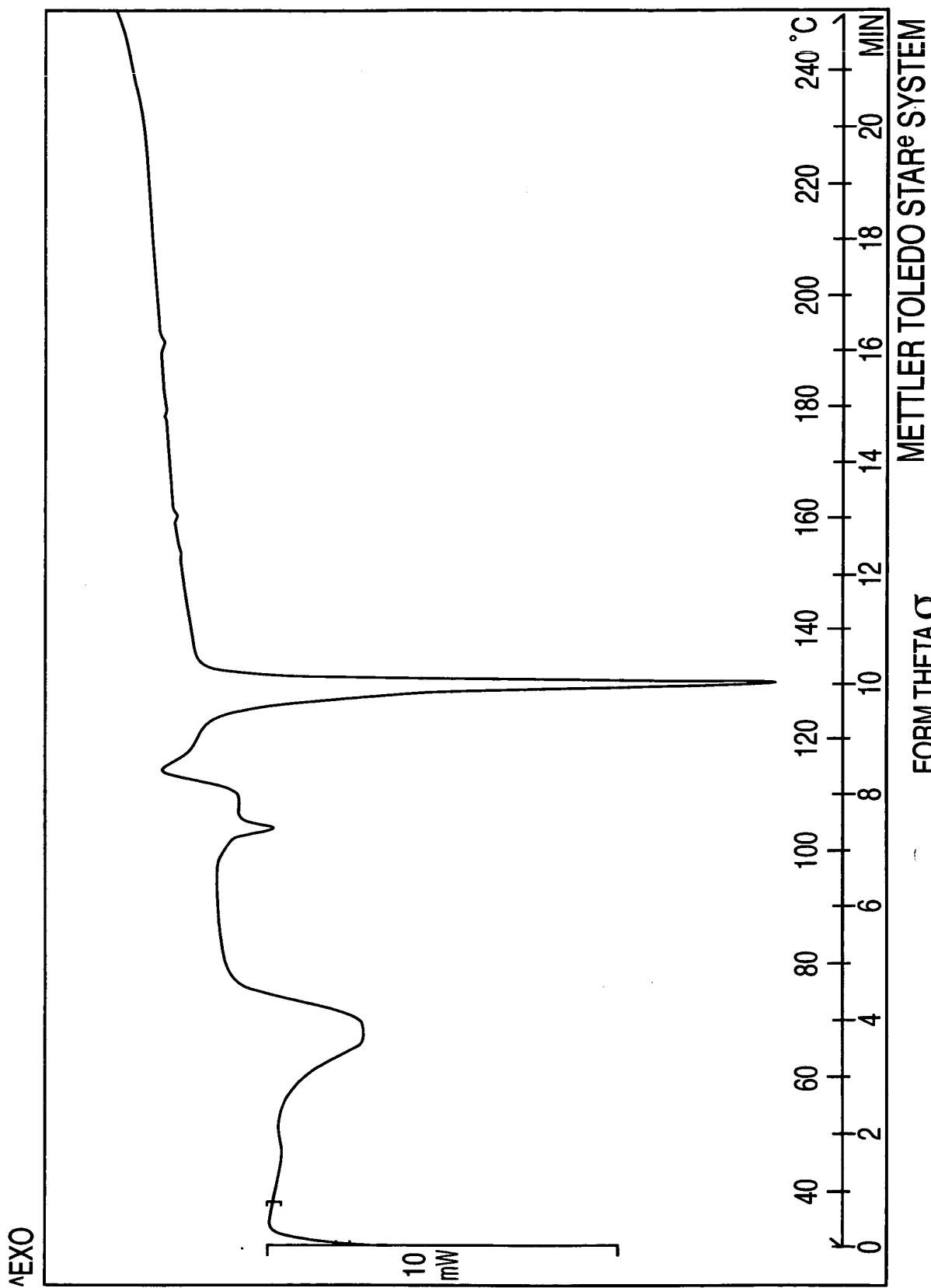


FIG. 62

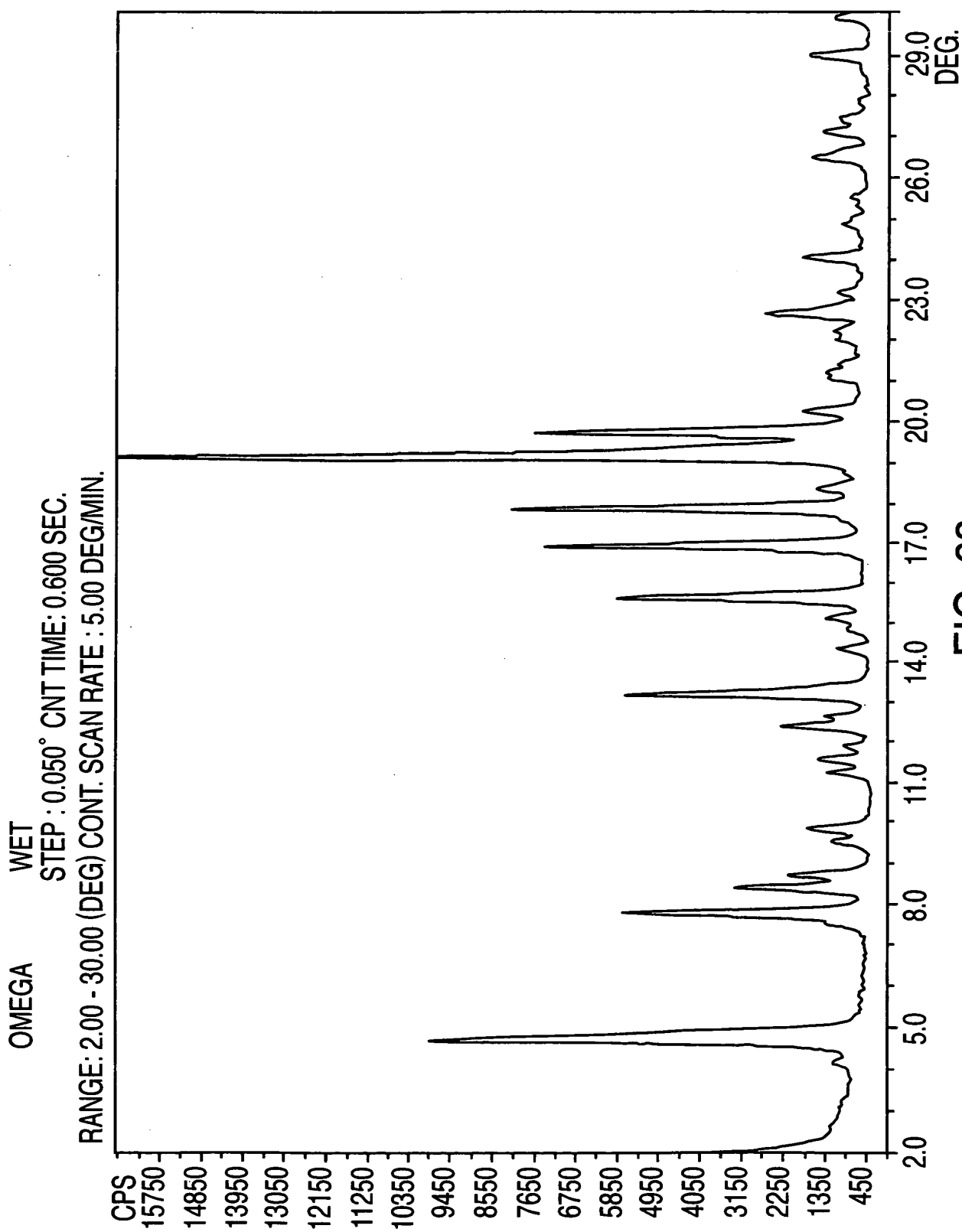


FIG. 63

Comparison between the impurity profile of Nateglinide crystallized in IPA-H₂O and Nateglinide crystallized in Methanol-H₂O

Sample No	Solvent	Impurity profile by RRT [% w/w]								
		D-PA (0.23)	(0.25)	(0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)	(1.76)	Isopropyl Ester (2.3)
RL-2155/1	Methanol-H ₂ O	<0.01		0.02	<0.01	0.03	0.02	2.91	0.04	
RL-2163/4	IPA-H ₂ O	<0.01	0.04		0.02	0.02	0.01		0.03	0.02

Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

(-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

FIG. 64